

PATENT COOPERATION TREATY

WO 99/33600
PCT/IB98/02046

From the INTERNATIONAL BUREAU

28 Rec'd PCT/PTO 10 AUG 1999

NOTICE INFORMING THE APPLICANT OF THE COMMUNICATION OF THE INTERNATIONAL APPLICATION TO THE DESIGNATED OFFICES

(PCT Rule 47.1(c), first sentence)

To: LANZONI, Luciano
Bugnion S.p.A.
Via dei Mille, 19
I-40121 Bologna
ITALIE

BUGNION - BOLOGNA
RECEIVED
20 LUG 1999
RICEVUTO

Date of mailing (day/month/year) 08 July 1999 (08.07.99)		
Applicant's or agent's file reference 61.G3440.WO7		IMPORTANT NOTICE
International application No. PCT/IB98/02046	International filing date (day/month/year) 17 December 1998 (17.12.98)	Priority date (day/month/year) 24 December 1997 (24.12.97)
Applicant GIBEN IMPIANTI S.P.A. et al		

1. Notice is hereby given that the International Bureau has communicated, as provided in Article 20, the international application to the following designated Offices on the date indicated above as the date of mailing of this Notice:
CN,EP,JP,US

In accordance with Rule 47.1(c), third sentence, those Offices will accept the present Notice as conclusive evidence that the communication of the international application has duly taken place on the date of mailing indicated above and no copy of the international application is required to be furnished by the applicant to the designated Office(s).

2. The following designated Offices have waived the requirement for such a communication at this time:
BR,CA,CZ,MX,NO,NZ,PL,RO,SI

The communication will be made to those Offices only upon their request. Furthermore, those Offices do not require the applicant to furnish a copy of the international application (Rule 49.1(a-bis)).

3. Enclosed with this Notice is a copy of the international application as published by the International Bureau on
08 July 1999 (08.07.99) under No. WO 99/33600

REMINDER REGARDING CHAPTER II (Article 31(2)(a) and Rule 54.2)

If the applicant wishes to postpone entry into the national phase until 30 months (or later in some Offices) from the priority date, a demand for international preliminary examination must be filed with the competent International Preliminary Examining Authority before the expiration of 19 months from the priority date.

It is the applicant's sole responsibility to monitor the 19-month time limit.

Note that only an applicant who is a national or resident of a PCT Contracting State which is bound by Chapter II has the right to file a demand for international preliminary examination.

REMINDER REGARDING ENTRY INTO THE NATIONAL PHASE (Article 22 or 39(1))

If the applicant wishes to proceed with the international application in the national phase, he must, within 20 months or 30 months, or later in some Offices, perform the acts referred to therein before each designated or elected Office.

For further important information on the time limits and acts to be performed for entering the national phase, see the Annex to Form PCT/IB/301 (Notification of Receipt of Record Copy) and Volume II of the PCT Applicant's Guide.

<p>The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland</p> <p>Facsimile No. (41-22) 740.14.35</p>	<p>Authorized officer J. Zahra</p> <p>Telephone No. (41-22) 338.83.38</p>
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PARENT COOPERATION TREATY

28 Rec'd PCT/PTO 10 AUG 1999
 PCT INTERNATIONAL BUREAU

**NOTIFICATION CONCERNING
 SUBMISSION OR TRANSMITTAL
 OF PRIORITY DOCUMENT**

(PCT Administrative Instructions, Section 411)

To:

LANZONI, Luciano
 Bugnion S.p.A.
 Via dei Mille, 19
 I-40121 Bologna
 ITALIE

Date of mailing (day/month/year) 29 December 1998 (29.12.98)	
Applicant's or agent's file reference 61.G3440.WO7	IMPORTANT NOTIFICATION
International application No. PCT/IB98/02046	International filing date (day/month/year) 17 December 1998 (17.12.98)
International publication date (day/month/year) Not yet published	Priority date (day/month/year) 24 December 1997 (24.12.97)
Applicant GIBEN IMPIANTI S.P.A. et al	

1. The applicant is hereby notified of the date of receipt (except where the letters "NR" appear in the right-hand column) by the International Bureau of the priority document(s) relating to the earlier application(s) indicated below. Unless otherwise indicated by an asterisk appearing next to a date of receipt, or by the letters "NR", in the right-hand column, the priority document concerned was submitted or transmitted to the International Bureau in compliance with Rule 17.1(a) or (b).
2. This updates and replaces any previously issued notification concerning submission or transmittal of priority documents.
3. An asterisk(*) appearing next to a date of receipt, in the right-hand column, denotes a priority document submitted or transmitted to the International Bureau but not in compliance with Rule 17.1(a) or (b). In such a case, **the attention of the applicant is directed** to Rule 17.1(c) which provides that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.
4. The letters "NR" appearing in the right-hand column denote a priority document which was not received by the International Bureau or which the applicant did not request the receiving Office to prepare and transmit to the International Bureau, as provided by Rule 17.1(a) or (b), respectively. In such a case, **the attention of the applicant is directed** to Rule 17.1(c) which provides that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.

<u>Priority date</u>	<u>Priority application No.</u>	<u>Country or regional Office or PCT receiving Office</u>	<u>Date of receipt of priority document</u>
24 Dece 1997 (24.12.97)	B097A000740	IT	18 Dece 1998 (18.12.98)

The International Bureau of WIPO
 34, chemin des Colombettes
 1211 Geneva 20, Switzerland

Authorized officer

S. De Michiel

Facsimile No. (41-22) 740.14.35

Telephone No. (41-22) 338.83.38

PCT

REQUEST

RECEIVED POL/PTC 10 AUG 1999

The undersigned requests that the present international application be processed according to the Patent Cooperation Treaty.

For receipt, Office use only

International Application No.

International Filing Date

Name of receiving Office and "PCT International Application"

Applicant's or agent's file reference

(if desired) (12 characters maximum) 61.G3440.W07

Box No. I TITLE OF INVENTION

A panel sawing machine and the related cutting method.

Box No. II APPLICANT

Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country. The country of the address indicated in this Box is the applicant's State (that is, country) of residence if no State of residence is indicated below.)

GIBEN IMPIANTI S.p.A.
Via Garganelli, 24
40065 PIANORO
ITALY

☐ This person is also inventor.

Telephone No.

Facsimile No.

Teleprinter No.

State (that is, country) of nationality: ITALY

State (that is, country) of residence: ITALY

This person is applicant for the purposes of:

☐

all designated States

☒

all designated States except the United States of America

☐

the United States of America only

☐

the States indicated in the Supplemental Box

Box No. III FURTHER APPLICANT(S) AND/OR (FURTHER) INVENTOR(S)

Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country. The country of the address indicated in this Box is the applicant's State (that is, country) of residence if no State of residence is indicated below.)

BENUZZI Piergiorgio
Via dell'Angelo Custode, 7
40121 BOLOGNA
ITALY

This person is:

☐ applicant only☒ applicant and inventor☐ inventor only (If this check-box is marked, do not fill in below.)

State (that is, country) of nationality: ITALY

State (that is, country) of residence: ITALY

This person is applicant for the purposes of:

☐

all designated States

☐

all designated States except the United States of America

☒

the United States of America only

☐

the States indicated in the Supplemental Box

☐ Further applicants and/or (further) inventors are indicated on a continuation sheet.

Box No. IV AGENT OR COMMON REPRESENTATIVE; OR ADDRESS FOR CORRESPONDENCE

The person identified below is hereby/has been appointed to act on behalf of the applicant(s) before the competent International Authorities as:

☒

agent

☐

common representative

Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country.)

LANZONI Luciano
BUGNION S.p.A.
Via dei Mille, 19
40121 BOLOGNA
ITALY

Telephone No.

051 252150

Facsimile No.

051 252106

Teleprinter No.

☐ Address for correspondence: Mark this check-box where no agent or common representative is/has been appointed and the space above is used instead to indicate a special address to which correspondence should be sent.

Box No.V DESIGNATION OF STATES

The following designations are hereby made under Rule 4.9(a) (mark the applicable check-boxes; at least one must be marked):

Regional Patent

- ☐ AP ARIPO Patent: GH Ghana, GM Gambia, KE Kenya, LS Lesotho, MW Malawi, SD Sudan, SZ Swaziland, UG Uganda, ZW Zimbabwe, and any other State which is a Contracting State of the Harare Protocol and of the PCT
- ☐ EA Eurasian Patent: AM Armenia, AZ Azerbaijan, BY Belarus, KG Kyrgyzstan, KZ Kazakhstan, MD Republic of Moldova, RU Russian Federation, TJ Tajikistan, TM Turkmenistan, and any other State which is a Contracting State of the Eurasian Patent Convention and of the PCT
- ☒ EP European Patent: AT Austria, BE Belgium, CH and LI Switzerland and Liechtenstein, CY Cyprus, DE Germany, DK Denmark, ES Spain, FI Finland, FR France, GB United Kingdom, GR Greece, IE Ireland, IT Italy, LU Luxembourg, MC Monaco, NL Netherlands, PT Portugal, SE Sweden, and any other State which is a Contracting State of the European Patent Convention and of the PCT
- ☐ OA OAPI Patent: BF Burkina Faso, BJ Benin, CF Central African Republic, CG Congo, CI Côte d'Ivoire, CM Cameroon, GA Gabon, GN Guinea, ML Mali, MR Mauritania, NE Niger, SN Senegal, TD Chad, TG Togo, and any other State which is a member State of OAPI and a Contracting State of the PCT (if other kind of protection or treatment desired, specify on dotted line)

National Patent (if other kind of protection or treatment desired, specify on dotted line):

- | | |
|---|---|
| <input type="checkbox"/> AL Albania | <input type="checkbox"/> LS Lesotho |
| <input type="checkbox"/> AM Armenia | <input type="checkbox"/> LT Lithuania |
| <input type="checkbox"/> AT Austria | <input type="checkbox"/> LU Luxembourg |
| <input type="checkbox"/> AU Australia | <input type="checkbox"/> LV Latvia |
| <input type="checkbox"/> AZ Azerbaijan | <input type="checkbox"/> MD Republic of Moldova |
| <input type="checkbox"/> BA Bosnia and Herzegovina | <input type="checkbox"/> MG Madagascar |
| <input type="checkbox"/> BB Barbados | <input type="checkbox"/> MK The former Yugoslav Republic of Macedonia |
| <input type="checkbox"/> BG Bulgaria | <input type="checkbox"/> MN Mongolia |
| <input checked="" type="checkbox"/> BR Brazil | <input type="checkbox"/> MW Malawi |
| <input type="checkbox"/> BY Belarus | <input checked="" type="checkbox"/> MX Mexico |
| <input checked="" type="checkbox"/> CA Canada | <input checked="" type="checkbox"/> NO Norway |
| <input type="checkbox"/> CH and LI Switzerland and Liechtenstein | <input checked="" type="checkbox"/> NZ New Zealand |
| <input checked="" type="checkbox"/> CN China | <input checked="" type="checkbox"/> PL Poland |
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| <input checked="" type="checkbox"/> CZ Czech Republic | <input checked="" type="checkbox"/> RO Romania |
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| <input type="checkbox"/> GB United Kingdom | <input type="checkbox"/> SK Slovakia |
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| <input type="checkbox"/> GM Gambia | <input type="checkbox"/> TM Turkmenistan |
| <input type="checkbox"/> GW Guinea-Bissau | <input type="checkbox"/> TR Turkey |
| <input type="checkbox"/> HR Croatia | <input type="checkbox"/> TT Trinidad and Tobago |
| <input type="checkbox"/> HU Hungary | <input type="checkbox"/> UA Ukraine |
| <input type="checkbox"/> ID Indonesia | <input type="checkbox"/> UG Uganda |
| <input type="checkbox"/> IL Israel | <input checked="" type="checkbox"/> US United States of America |
| <input type="checkbox"/> IS Iceland | <input type="checkbox"/> UZ Uzbekistan |
| <input checked="" type="checkbox"/> JP Japan | <input type="checkbox"/> VN Viet Nam |
| <input type="checkbox"/> KE Kenya | <input type="checkbox"/> YU Yugoslavia |
| <input type="checkbox"/> KG Kyrgyzstan | <input type="checkbox"/> ZW Zimbabwe |
| <input type="checkbox"/> KP Democratic People's Republic of Korea | |
| <input type="checkbox"/> KR Republic of Korea | |
| <input type="checkbox"/> KZ Kazakhstan | |
| <input type="checkbox"/> LC Saint Lucia | |
| <input type="checkbox"/> LK Sri Lanka | |
| <input type="checkbox"/> LR Liberia | |

Check-boxes reserved for designating States (for the purposes of a national patent) which have become party to the PCT after issuance of this sheet:

Precautionary Designation Statement: In addition to the designations made above, the applicant also makes under Rule 4.9(b) all other designations which would be permitted under the PCT except any designation(s) indicated in the Supplemental Box as being excluded from the scope of this statement. The applicant declares that those additional designations are subject to confirmation and that any designation which is not confirmed before the expiration of 15 months from the priority date is to be regarded as withdrawn by the applicant at the expiration of that time limit. (Confirmation of a designation consists of the filing of a notice specifying that designation and the payment of the designation and confirmation fees. Confirmation must reach the receiving Office within the 15-month time limit.)

Box No. VI PRIORITY CLAIM		<input type="checkbox"/> Further priority claim indicated in the Supplemental Box.		
Filing date of earlier application (day/month/year)	Number of earlier application	Where earlier application is:		
		national application: country	regional application: regional Office	international application: receiving Office
item (1) 24 December 1997 (24.12.97)	B097A 000740	ITALY		
item (2)				
item (3)				

☐ The receiving Office is requested to prepare and transmit to the International Bureau a certified copy of the earlier application(s) (only if the earlier application was filed with the Office which for the purposes of the present international application is the receiving Office) identified above as item(s):

* Where the earlier application is an ARIPO application, it is mandatory to indicate in the Supplemental Box at least one country party to the Paris Convention for the Protection of Industrial Property for which that earlier application was filed (Rule 4.10(b)(ii)). See Supplemental Box.

Box No. VII INTERNATIONAL SEARCHING AUTHORITY

Choice of International Searching Authority (ISA) (if two or more International Searching Authorities are competent to carry out the international search, indicate the Authority chosen; the two-letter code may be used):

ISA / EP

Request to use results of earlier search; reference to that search (if an earlier search has been carried out by or requested from the International Searching Authority):

Date (day/month/year)

Number

Country (or regional Office)

Box No. VIII CHECK LIST; LANGUAGE OF FILING

This international application contains the following number of sheets:

request : 3
description (excluding sequence listing part) : 16
claims : 6
abstract : 1
drawings : 15
sequence listing part of description :
Total number of sheets : 41

This international application is accompanied by the item(s) marked below:

1. ☒ fee calculation sheet
2. ☒ separate signed power of attorney
3. ☐ copy of general power of attorney; reference number, if any:
4. ☐ statement explaining lack of signature
5. ☒ priority document(s) identified in Box No. VI as item(s): 1
6. ☐ translation of international application into (language):
7. ☐ separate indications concerning deposited microorganism or other biological material
8. ☐ nucleotide and/or amino acid sequence listing in computer readable form
9. ☐ other (specify):

Figure of the drawings which should accompany the abstract: 2

Language of filing of the international application: ENGLISH

Box No. IX SIGNATURE OF APPLICANT OR AGENT

Next to each signature, indicate the name of the person signing and the capacity in which the person signs (if such capacity is not obvious from reading the request).


(Luciano LANZONI) - Agent

For receiving Office use only		2. Drawings: <input type="checkbox"/> received: <input type="checkbox"/> not received:
1. Date of actual receipt of the purported international application:		
3. Corrected date of actual receipt due to later but timely received papers or drawings completing the purported international application:		
4. Date of timely receipt of the required corrections under PCT Article 11(2):		
5. International Searching Authority (if two or more are competent): ISA /	6. <input type="checkbox"/> Transmittal of search copy delayed until search fee is paid.	

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Date of receipt of the record copy by the International Bureau:

PCT

FEE CALCULATION SHEET

Annex to the Request

For receiving Office use only

International application No.

Date stamp of the receiving Office

Applicant's or agent's
file reference 61.G3440.W07

Applicant

GIBEN IMPIANTI S.p.A. et al.

CALCULATION OF PRESCRIBED FEES

1. TRANSMITTAL FEE CHF 300 [T]

2. SEARCH FEE CHF 1,850 [S]

International search to be carried out by European Patent Office

(If two or more International Searching Authorities are competent in relation to the international application, indicate the name of the Authority which is chosen to carry out the international search.)

3. INTERNATIONAL FEE

Basic Fee

The international application contains 41 sheets.

first 30 sheets CHF 650 [b1]

11 x 15 = 165 [b2]
remaining sheets additional amount

Add amounts entered at b1 and b2 and enter total at B CHF 815 [B]

Designation Fees

The international application contains 13 designations.

11 x 150 = 1,650 [D]
number of designation fees amount of designation fee payable (maximum 11)

Add amounts entered at B and D and enter total at I CHF 2,465 [I]

(Applicants from certain States are entitled to a reduction of 75% of the international fee. Where the applicant is (or all applicants are) so entitled, the total to be entered at I is 25% of the sum of the amounts entered at B and D.)

4. FEE FOR PRIORITY DOCUMENT (if applicable) [P]

5. TOTAL FEES PAYABLE CHF 4,615

Add amounts entered at T, S, I and P, and enter total in the TOTAL box

TOTAL

☐ The designation fees are not paid at this time.

MODE OF PAYMENT

☒ authorization to charge
deposit account (see below)

☐ bank draft

☐ coupons

☐ cheque

☐ cash

☐ other (specify):

☐ postal money order

☐ revenue stamps

DEPOSIT ACCOUNT AUTHORIZATION (this mode of payment may not be available at all receiving Offices)

The RO/ 101 ☒ is hereby authorized to charge the total fees indicated above to my deposit account.

☒ is hereby authorized to charge any deficiency or credit any overpayment in the total fees indicated above to my deposit account.

☐ is hereby authorized to charge the fee for preparation and transmittal of the priority document to the International Bureau of WIPO to my deposit account.

18410 BUGNION S.p.A. December 15, 1998

Deposit Account No.

Date (day/month/year)

Signature (Luciano LANZONI)

PCT

POWER OF ATTORNEY

(for an international application filed under the Patent Cooperation Treaty)

(PCT Rule 90.4)

The undersigned applicant(s) (Names should be indicated as they appear in the request):

GIBEN IMPIANTI S.p.A.
Via Garganelli, 24
40065 PIANORO (BOLOGNA)
ITALY

BENUZZI Piergiorgio
Via dell'Angelo Custode, 7
40121 BOLOGNA
ITALY

hereby appoints (appoint) the following person as:



agent



common representative

Name and address

(Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country.)

LANZONI Luciano
BUGNION S.p.A.
Via dei Mille, 19
40121 BOLOGNA
ITALY

to represent the undersigned before



all the competent International Authorities



the International Searching Authority only



the International Preliminary Examining Authority only

in connection with the international application identified below:

Title of the invention: A panel sawing machine and the related cutting method.

Applicant's or agent's file reference: 61.G3440.W07

International application number (if already available):

filed with the following Office The International Bureau of WIPO - GENEVA as receiving Office
and to make or receive payments on behalf of the undersigned.

Signature of the applicant(s) (where there are several applicants, each of them must sign; next to each signature, indicate the name of the person signing and the capacity in which the person signs, if such capacity is not obvious from reading the request or this power):

GIBEN IMPIANTI S.p.A.

(Piergiorgio BENUZZI) - Managing Director

(Piergiorgio BENUZZI)

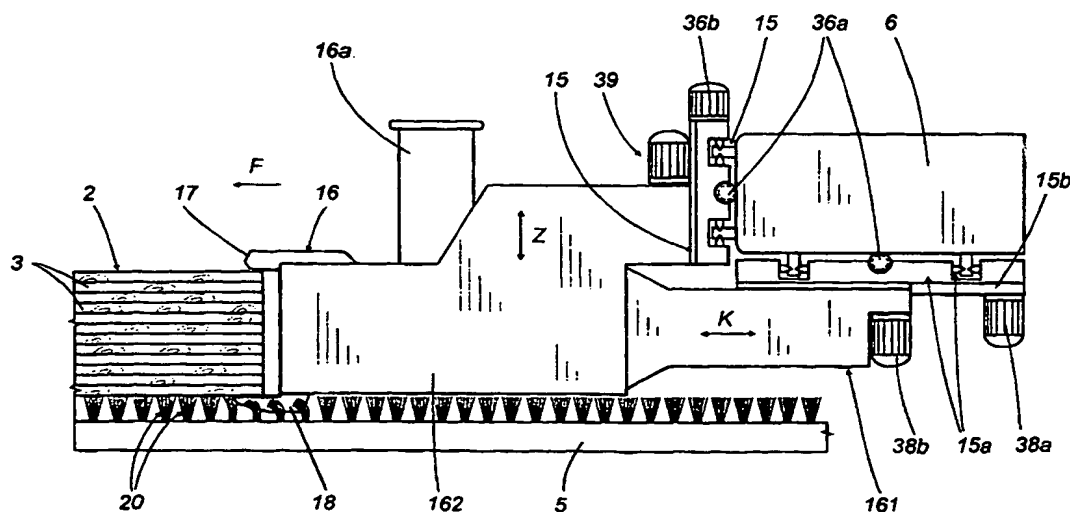
Date: December 15, 1998



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B23D 47/04, B27B 5/06	A1	(11) International Publication Number: WO 99/33600 (43) International Publication Date: 8 July 1999 (08.07.99)
(21) International Application Number: PCT/IB98/02046 (22) International Filing Date: 17 December 1998 (17.12.98) (30) Priority Data: BO97A000740 24 December 1997 (24.12.97) IT (71) Applicant (for all designated States except US): GIBEN IMPIANTI S.P.A. [IT/IT]; Via Garganelli, 24, I-40065 Pianoro (IT). (72) Inventor; and (75) Inventor/Applicant (for US only): BENUZZI, Piergiorgio [IT/IT]; Via dell'Angelo Custode, 7, I-40121 Bologna (IT). (74) Agent: LANZONI, Luciano; Bugnion S.p.A., Via dei Mille, 19, I-40121 Bologna (IT).		(81) Designated States: BR, CA, CN, CZ, JP, MX, NO, NZ, PL, RO, SI, US, European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i>

(54) Title: METHOD AND MACHINE FOR SAWING PANELS WITH Laterally MOVABLE PUSHER

**(57) Abstract**

A panel sawing machine comprises a horizontal table (5) on which a movable device (6) pushes a stack of panels (3a) in a forward direction (F) or reverse direction (F1) to feed a sawing device (or to a device for rotating the stack) which divides the panel up into two or more smaller boards. The pusher (6) is equipped with two or more pickup elements (16) that hold the rear edge of the stack in position during positioning and/or sawing operations. The pickup elements (16) are mounted on the movable device (6) in such a way that they can run in guides (15, 15a, 15b) in the following three directions, respectively: horizontal at right angles to, and horizontal parallel to, the forward direction (F) or the reverse direction (F1), and vertical.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
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EE	Estonia	LR	Liberia	SG	Singapore		

Description**METHOD AND MACHINE FOR SAWING PANELS WITH Laterally MOVABLE PUSHER**Technical Field

The present invention relates to a panel sawing machine. The invention can be used in particular, but not solely, to cut panels, slabs or sheets made especially of wood-based materials but also of plastic, light metal alloys, steel and composite and mineral-bonded board, in order to form smaller boards.

The invention applies in particular to machine for sawing wood-based materials and comprising a horizontal table on which a movable device, usually known as pusher, can push at least one panel to a device downstream for sawing (or rotating) the panel, where, during the sawing operation, the panel is positioned by suitable pickup elements which grip the rear edge of the panel, and including any additional positioning, aligning, outfeed, pressing and rotating elements that constitute the standard equipment of these machines.

Background Art

Known machines of this kind are normally equipped with a plurality of pickup elements, for example of the gripper type, mounted side by side in a given direction at right angles to the forward (or reverse) feed direction of the panels and acting on the rear edge of the panels to be cut.

These known panel sawing machines are used to cut panels of various sizes, both in width and length, usually placed one over the other in normally large stacks whose dimensions depend on the size of the panels made by the panel forming machines.

Conventional panel sawing machines may be of the simple type, with a single cutting axis, called lengthways axis, located downstream of the pusher, or more complex, with two (or more) cutting axes at an angle to each other and with panel feed tables positioned at 90° to each other. In these more complex machines,

the cutting axes are downstream of the corresponding pushers, the first axis being called the lengthways axis and the second, the crossways axis.

5 In these known machines, the same pusher can also be used to saw two or more stacks of panels or boards in succession. In addition, stacks of different sized boards placed side by side can only be sawn simultaneously if the cutting line of the different stacks corresponds with the machine cutting axis concerned (creating what is usually known as a logical cutting pattern). If
10 the cuts are not consistent (creating differentiated cutting patterns) several pushers may be provided, each acting on one (or more) board/boards or portion of panel and resulting in constructional complications and additional costs for the entire machine.

15 Depending on the size (whether initial or derived from pre-cuts) of the stack of panels or group of boards to be sawn, the machine must be equipped with a suitable number of pickup elements appropriately positioned and distributed along the entire rear edge of the related stack or group of boards so as to firmly hold
20 the panels along the entire width and to line them up securely against a stop surface during the sawing operation.

One of the disadvantages of known panel sawing machines is that all of them are set up and equipped to cut a limited number of sizes of panel stacks or groups of panel stacks. This is
25 accomplished by mounting on the pusher crossbeam a variable number of pickup elements or grippers, depending on the requirements of the end user. In other words, the manufacturer equips the pusher crossbeam with a number of pickup elements or grippers, variously distributed along the length of the beam, at fixed positions,
30 using the smallest number of elements possible in order to reduce costs.

These machines are therefore rather inflexible in terms of size changeover and hence are not suitable for cutting panels of many different sizes unless fitted with complex equipment, which
35 considerably raises construction costs and requires expensive tooling; not to mention the fact that, although machines of this kind are long-term investments, its capabilities are unable to

satisfy process requirements after many years in operation, not least because of the diverse and constantly changing market requirements.

5 Disclosure of the Invention

 The present invention has for its principal object to overcome the disadvantages of prior art by providing a panel sawing machine, with either one or two (or more) cutting axes, that can be adjusted in an extremely simple and practical manner to work on panels or boards or groups of boards of any size.

 One advantage of the present invention is that it permits two or more panels and/or boards in stacks placed side by side to be cut lengthways or crossways (depending on which machine axis is being used) even if the adjacent panels and/or boards must be sawn into smaller boards or panels differing in length and width from one panel or board to the next.

 Another advantage is that it provides a machine that can be used to make boards of various sizes both in width and length with a relatively small number of cutting operations and allowing considerable saving of time.

 The above mentioned aims and advantages are all achieved by the present invention as characterized in the claims below.

 Other characteristics and advantages of the invention are made more apparent in the detailed description which follows, with reference to the accompanying drawings, which illustrate a preferred embodiment of the invention and in which:

 - Figure 1 is a schematic top plan view of a machine made in accordance with the present invention and being of the type with a single, lengthways cutting axis;

 - Figure 2 is a scaled-up, right-hand side view of a detail of Figure 1;

 - Figures 3a to 3f are schematic top views of possible cutting configurations using two grippers in accordance with the present invention;

 - Figures 4a to 4d1 are schematic top views of possible working configurations of the machine illustrated in Figure 1,

differing according to the size of the panels to be cut and the characteristics of the machine itself;

- Figures 5a to 5u are schematic top views of possible working configurations of a machine with two (angular) cutting axes, differing according to the size of the panels to be cut and the characteristics of the machine itself.

- Figures 6a to 6f are schematic top views of different stages in the cutting operations that can be carried out with the machine disclosed by the present invention.

With reference to Figure 1, the numeral 1 indicates as a whole a panel sawing machine with a single, lengthways cutting axis used normally to cut whole panels 30 of large size (such as that illustrated) or panels 3a and 3b placed side by side. In the present description, reference is made to the cutting of panels made of wood or from a wood-based material but without thereby restricting the scope of the invention.

The machine 1 is designed to cut panels 30 or 3a, 3b into smaller boards 31 or 4a, 4b, respectively, having the same or different width L.

The machine 1 comprises a horizontal table 5 that supports at least one panel to be cut. The table is made in such a way as to permit the panel to easily slide on it in a forward feed direction, indicated by the arrow F, or in the opposite direction F1, in the case of a panel or stack of panels fed from the machine front/operator side OP (as described in more detail below). In this particular case, the table 5 is loaded by conventional feeding and loading means (not illustrated) with one or more stacks of panels. By way of example, Figure 1 shows two stacks 2a and 2b of panels placed side by side, which, alternatively, might constitute a single stack 2 (see Figure 2) not larger in size than the sum of the dimensions of the stacks 2a and 2b.

The panel table might, for example, comprise a plurality of idle rollers turning about axes perpendicular and/or parallel to the feed direction or, in another preferred embodiment, illustrated in Figure 2, the table may comprise a plurality of brush-like supporting elements 20 (either low-friction fibre or air-cushion), the tops of which form a horizontal surface on which

the panels can slide. The table may also be equipped with a rotation device, illustrated schematically and labelled R, which, when necessary, turns the panel through 90°, as described in more detail below with reference to the illustrations showing the different process stages. In the most simple embodiment, the rotation device may consist of a gripper which grips a corner of the panel and moves in direction F, F1 so as to turn the panel.

The machine is equipped with means for moving the panels along the table 5 in the feed direction F or F1, said means comprising a movable device 6 designed to push the panels 3 or 3a, 3b along the table 5 in direction F (or to pull them in direction F1) towards a lengthways sawing device 7 designed to divide the panels into smaller boards. The pusher 6 consists essentially of a crossbeam able to move in the feed direction F (or F1) in steps of preset length in such a way as to feed stacks 2 or 2a, 2b of panels to the sawing device 7. During stops between one step and the next, the sawing device 7 cuts the stacks of panels at right angles to the feed direction F.

The numeral 50 indicates air-cushion tables located on the operator side OP and designed to support and receive the panels feeding into or out of the sawing device 7. The letters SX and DX indicate the zero reference lines for the left-hand and right-hand sides of the machine, respectively.

The boards 4 or 4a, 4b feeding out of the sawing device 7 are then transferred to further process stations which are not illustrated in the drawings.

The pusher 6 has at least one pickup element 16 designed to hold the panels in position during the sawing operation. Each pickup element 16 acts on a part of the rear edge of a panel and prevents the edge from moving while the panel is being sawed.

The device 6 is preferably equipped with a plurality of pickup elements (as illustrated in Figure 1) placed side by side in a horizontal direction at right angles to the panel feed direction. Each pickup element may, for example, comprise a gripper consisting of a first clamping part 17 designed to press down on the edge of the panel at the top of the stack and a second clamping part 18 which acts on the lower edge of the panel: in

this case, the clamping parts 17 and 18 work together to form two jaws that hold the entire stack by its rear edge.

The clamping parts 17 and 18 are actuated by conventional drive means, illustrated schematically in Figure 2, such as a
5 fluid drive unit 16a.

Figure 1 shows a plurality of pickup elements 16, irregularly spaced apart in a direction at right angles to F. In the case illustrated here, the distribution of the elements is more concentrated on the left-hand side, which is the reference
10 side SX for the sawing of the stack of panels, although the right-hand reference side DX could also be used, as described below. Preferably, for the convenience of modular construction, all the pickup elements are identical.

According to the present invention, at least one of the
15 pickup elements 16 (or better still, all of them except the first from the left, labelled 160) must be mounted on the pusher 6 in such a way as to be able to move crossways in both directions, in a horizontal direction indicated by an arrow H in Figure 1, at right angles to the direction of feed.

20 This could be achieved by a sliding fit between the pickup element 16 and a first straight, horizontal guide 15, integral with the pusher 6 and schematically represented in Figure 2.

Means, illustrated schematically in Figure 1 and labelled 36, are also envisaged for controlling the left and right
25 crossways movements of the different pickup elements 16. These control means may, for example, consist of a helical guide 36a, integral with the crossbeam 6 and engaged by a power-driven unit, labelled 36b, operated by a lead screw and integral with each pickup element 16. These control means are computerized and
30 designed to locate the pickup elements along the rear edge of a panel at the positions most suitable to ensure a safe and secure hold on the panel, however wide the latter is and whatever its crossways position relative to the table.

In this regard, Figures 3a to 3f schematically illustrate
35 six different positions that may be assumed by two pickup elements 16 according to the number and size of the panels 3 to be sawed. In practice, by appropriately positioning a relatively small

number of pickup elements 16 (in this case, only two) in a crossways direction, panels 3 of any size can be held in position while they are being sawed.

Thanks to this controlled positioning solution, only a few
5 elements 16 are needed to securely hold two or more panels placed side by side, to be sawed at the same time by the same sawing device or sets of different sized panels fed in one after the other. That makes for a practically universal machine that can be used for panels of any size and that can be controlled by an
10 operator (or by a control system capable of recognizing panel dimensions) through simple setting operations that require very little time and hence result in negligible down time.

Figures 3a to 3f are simple illustrations of how panels of different sizes can be handled using only two pickup elements,
15 which is the minimum number of elements required.

Figures 3a to 3c show some possible working configurations of the grippers on the pusher 6 that differ according to the width of the boards to be cut: notice that the grippers are located at the positions most suited to the width of the board or stack of
20 boards.

In the case of a single board, as shown in Figure 3a, gripper 16a alone is sufficient, while in the case of two boards 3 side by side, as shown in Figure 3b, the gripper 16b must also be used. Similarly, in the example illustrated in Figure 3c, where
25 each of the grippers 16a, 16b is used to hold two (or more) thinner half-boards, the size and carrying capacity of the grippers are such as to enable more than one board (Figure 3c shows two) to be simultaneously pulled in direction F1 or pushed in direction F.

Figures 3d to 3f, on the other hand, show the grippers on
30 the pusher 6 positioned differently according to the different sizes of a single large panel 3. Again, notice that the grippers are located at the positions most suited to the dimensions of the panel or stack of panels both in the lengthways direction (Figures 3e, 3f) and in the crossways direction to enable them to be pre-cut (see Figure 3d).
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Another feature of the invention is that at least one of the pickup elements 16, the one labelled 161 in Figure 2, may move not only crossways relative to the pusher 6, in direction H, but also lengthways in the both the forward or reverse feed directions, labelled K. The pickup element 161 is preferably positioned below the crossbeam 6, for structural reasons to enable it to move to the different positions, as described in more detail below. It moves in H by means of a second guide 15a and in K by means of a similar third guide 15b, each having a corresponding drive unit, also of known type, and represented conventionally as 38a and 38b.

There may be one or more pickup elements 161 able to make controlled movements in direction K, in which case each pickup element 161 must be equipped with drive means allowing it to move independently of the others.

Figure 2 shows that one or more of the elements 16, in this case labelled 162, may also move in a vertical direction Z along a fourth guide 15 and actuated by drive means 39: that means that the gripper concerned can be raised from the table so that the pusher crossbeam can return to the ready, retracted position by moving over the panel or stack of panels still being machined without touching it. This feature is described in more detail below.

The forward and return movements of the pickup elements 16, as well as their sideways and vertical movements along the three axes H, K and Z are controlled by a conventional, computerized controller unit (not illustrated) which drives all the machine axes.

Different working configurations that can be obtained with the machine described above will now be described with the aid of the schematic drawings of Figure 4.

In Figures 4a to 4f, the process cycle of the panel sawing machine envisages a single, lengthways cutting axis with loading of panels (or stacks of panels, from now on called just panels for convenience) from the front, that is, from the operator side OP. The grippers (see Figure 4a) are moved into position so as to be regularly spaced out in H along the length of the panel, referenced to the right-hand zero line DX: once the grippers 16

have got hold of the panel, the pusher moves back in direction F1. In Figure 4b, the pusher crossbeam pushes the panel in direction F for a first trimming cut T1, a second lengthways cut (at least one) T2 and a final trimming cut T3 (see Figure 4c). In Figure 4d, after the operator OP has turned the boards resulting from the cutting of the panel, the pusher moves back in direction F1 and the grippers have moved to the new position to hold the boards (in this example, there are two boards), this time referenced to the left-hand line SX. The pusher (see Figure 4e) pushes the boards to the first trimming cut T4 in direction F and then, see Figure 4f, continues moving forward in direction F so that at least one crossways cut T5 can be made: in this case, however, one or more of the grippers (in this illustration, only the one labelled 161) must also move in direction K so as to allow different positions relative to the pusher crossbeam 6 which continues to move in direction F.

The process cycle illustrated in Figures 4g to 4r refers again to a panel sawing machine with a single, lengthways cutting axis and panel loading from the front, that is, from the operator side OP, but in this case having also an independent rotating device R. The grippers (see Figure 4g) are moved into position so as to be regularly spaced out in H along the length of the panel, referenced to the right-hand zero line DX: once the grippers 16 have got hold of the panel, the pusher moves back in direction F1. In Figure 4h, the pusher positions the panel according to a preset 0 rotation PT, the grippers 16 open, the pusher moves back a little and the grippers rise. The rotation device R (in practice a jointed gripper) now comes into operation, the device R illustrated in this example being of the linear type that moves along the axis of F1 and, in combination with a locating reference element B1 (in practice an opposing roller) rotates the panel through 90° (see Figure 4i). During the combined movement of the rotation device R and of the reference element B1, the pusher and the gripper move to a new position that will enable them to catch hold of the short side of the panel. The pusher moves forward (see Figure 4j), the grippers hold the panel by its short side and the pusher positions the panel first for trimming and then for the

pre-cut (or pre-cuts, see Figure 4k), after which the gripper 162 rises (see Figure 4l), while the outer right-hand gripper 16 and the pusher move to the left-hand zero position SX to be able to catch hold of and pull the pre-cut board (or boards) in direction F1. In the meantime, the rotation device R moving in direction F and the locating reference element B1 are free to rotate the panel again. Continuing the cycle, the pusher (see Figure 4m), with the gripper 16 located at the left-hand zero line SX, pulls the pre-cut board back in direction F1, past the cutting line and then (see Figure 4n) forward again in direction F to be cut crossways where required. When all the crossways cuts have been completed, the gripper 16 used up to now (see Figure 4o) also moves in H to a position where it can catch hold of the main portion of the panel previously rotated. When all the elements are in the correct position, the pusher proceeds in direction F to allow the lengthways cuts to be made where required (see Figure 4p) with reference to the right-hand zero line DX, the various different boards reaching the air-cushion table at the end, after which the grippers and the pusher move to the pickup position referenced to the opposite, left-hand side SX again. Notice, in Figure 4q, that the grippers have moved crossways in H to the position from which they can catch hold of the boards to pull them back past the cutting line. Finally, as shown in Figure 4r, the pusher moves forward, while the specially equipped gripper 161 moves forward or back along the axis K to permit the crossways cuts to be made along cutting lines that are at different distances from the ends of the panels.

The process cycle illustrated in Figures 4s to 4d1 again refers to a panel sawing machine with a single, lengthways cutting axis but in this case with a loader (or loading platform), labelled CA, located on the side opposite the air-cushion table 50. In Figure 4s, the whole panel is placed upstream of the panel saw and is then (see Figure 4t) transferred in direction F and aligned with the 0 PT both lengthways and crossways by the rotation device R (optional) and the reference element B1. Next, (see Figure 4u) the grippers rise in direction Z and the pusher is positioned in direction F1 to wait for the panel which is being

rotated. The grippers, referenced to the right-hand zero line DX (see Figure 4v) stop the panel after it has been rotated and the pusher moves forward in direction F (see Figure 4w) to make one or more cuts, after which the panels are rotated on the air-cushion table. The grippers not used at this stage are the one labelled 162, which rises in direction Z (see Figure 4x) and the one labelled 16 which will be used for the subsequent cutting of the boards moves in H with reference to the left-hand zero SX. In Figure 4y, the panel is rotated again and, at the same time, the pusher moves back in direction F1 with reference to the left-hand zero SX, taking the pre-cut board past the cutting line. The pusher then moves forward again (see Figure 4z) in steps to position the board so that it can be cut crossways at T10. In Figure 4a1, the pusher and the grippers move (in directions F and H, respectively) to catch hold of the main portion of the panel referenced to the right-hand zero DX and make the lengthways cuts T11. Next (see Figure 4b1), the boards cut in this way are rotated by the operator through 90° on the air-cushion table while the pusher and the grippers move back to the left-hand reference zone SX to catch hold of the boards. Lastly (see Figures 4c1 and 4d1) the pusher moves back to carry the boards past the cutting line and then forward in direction F again to position them for the crossways cuts not before the gripper 161 has moved along K to allow the two (or more) boards to be cut at the same time into different lengths relative to the pusher 6.

Figures 5a to 5u illustrate an angular panel sawing machine, that is, having two cutting axes, labelled 7 and 7a, at right angles to each other, the former called lengthways cutting axis and the latter, crossways cutting axis. The lengthways section of the machine has a pusher 6, with grippers 16, loading table CA, zero reference line SX (referred to as being on the left since the feed directions of the panel make an angle that coincides with the machine angle, which is on the left-hand side), and with cutting feed direction F. The crossways section of the machine has a pusher 6a, with grippers 16t and 16lt, zero reference line SXt and cutting feed direction F2 (see Figure 5a).

After being fed in in direction F (see Figure 5b), the first panel or stack of panels is pushed by the pusher 6 to the 0 PT position (optional) for the rotation device R and reference element B1, while the second panel 3a is ready on the loader CA.

5 The panel is rotated (see Figure 5c) while the pusher 6 moves back with the grippers 162 raised in direction Z so as not to interfere with the rotation of the panel. Then (see Figure 5d), the grippers 16 and 162 move into position in H to adapt to the length of the short side of the panel 3. The grippers 16 and 162 must therefore

10 be able to move in directions H and Z. In the next step (see Figure 5e), the pusher 6 moves in direction F to enable the panel to be cut into boards S1 along the axis 7. The boards S1 are then immediately gripped by the grippers 16t and 16lt of the crossways section, which move in direction F2 towards the second cutting

15 line 7a: in this configuration, the gripper 16t preferably, but not necessarily, moves in both directions H and Z, while the other grippers labelled 16lt can move not only in H but also in K, all or some of them in accordance with the cutting and operating requirements of the entire machine (H and K being the directions

20 of movement along the pusher crossbeam and perpendicular to it, respectively). In Figure 5f, while the crossbeam 6a moves the boards S1 into position and the gripper 16lt moves in direction K relative to it so as to be able to cut the boards into different lengths according to requirements, the remaining portion of the

25 panel 3 is rotated again with the crossbeam 6 retracted and the related grippers 16 raised in direction Z. Figure 5g shows the boards S1 after they have been positioned by the crossbeam 6a, while the pusher 6 moves the panel 3 forward in direction F again for a further cut 7 into boards S2 (see also Figure 5h). In this

30 case, four boards S2 are shown and therefore (as can be seen better in Figure 5i), one gripper 16t and two grippers 16lt are used. The latter are the grippers that position the boards for the crossways cut into different lengths (notice also that one of the grippers 16lt is holding two boards at the same time), while the

35 grippers that are not used - which this time are those labelled 160t - are positioned at the end of the crossbeam 6a, outside the range of the cutting stroke of the axis 7a. With reference to

Figure 5h again, the crossbeam 6a is shown during its return in direction F3 without the load. In this case, the grippers 16t, which vertically "cover" the area occupied by the boards S2, rise in direction Z so as not to interfere with the boards below, while the remaining grippers 160t, which are idle, are positioned on one side. The number of grippers 160t (and 16t) used and the length of the crossbeam 6a, are calculated in accordance with the working width L5 and the width of the overtravel L6. Similarly, the crossbeam 6 moves into position to catch hold of the next panel or stack of panels 3a which is illustrated in a lighter shade of grey. As mentioned above, Figure 5i shows that the four boards S2 are held by one gripper 16t, which moves in H and by two grippers 161t, which move in H and K, at least one of these being able to hold two or more boards at the same time, and that there are three grippers 160t lying idle on one side of the crossbeam 6a. Figure 5i also shows that the panel 3a is cut lengthways at 7 so as to be further divided into boards S3 that differ in width from boards S2 since successive panels can be cut according to completely different patterns. In Figure 5j, the crossbeam 6a is again returning in direction F3 without the load and with the grippers 16t raised above the boards S3 and the grippers 160t in the idle position on one side of the crossbeam 6a. In the meantime, the next panel 3b is being handled by the crossbeam 6. In Figure 5k, the cutting axis 7a is already working on the boards S3, with two grippers 16t holding the first board, (the larger one) and only one gripper 161t, holding the other two boards (the thinner ones). In the meantime, panel 3b is being sawn lengthways at 7.

Figures 5l to 5u show a machine with two cutting axes that works in the same way as the one just described but with crossbeam 6 of the lengthways section having at least one gripper 161 that can move both in H and in K so as to be able to handle two different panels 3h, 3k placed side by side. In Figure 5m, the two grippers 16 and 161 are pushing the panel 3h in direction F towards the cutting axis 7 which divides the panel 3h into a plurality of boards S4, the latter being then transferred to the crossbeam 6a. The crossbeam 6, now free, can pick up the other panel 3k. In Figure 5o, while the boards S4 are cut at right

angles to the final axis 7a, the panel 3k cut lengthways into boards S5. In the meantime, other panels 3m, 3n have been fed into the machine. In Figure 5p, while the boards S5 are cut crossways, the panel 3m is turned through 90° on the table of the lengthways section of the machine. In Figure 5q, the boards S5 are cut crossways into different lengths, the panel 3m is cut into boards S6 and the panel 3n is picked up by the crossbeam 6. Other panels 3p (already cut into two boards) and 3q are fed in from the loading table. Next, as shown in Figure 5r, while the boards S6 approach the final crossways cutting line, the panel 3n is cut lengthways into boards S7 and the crossbeam 6 transfers the twin-board panel 3p to the lengthways cutting line 7. As shown in Figure 5s, the boards S7 are cut crossways into different lengths and the panel 3p lengthways into boards of different widths at 7. Lastly, Figure 5u shows the latter panel being fed out of the machine after being cut, while the panel 3q is being fed to the cutting line 7.

Thus, thanks to the controlled movements of one or more pickup elements 16, the machine can cut panels, even panels placed edge to edge, into boards of different lengths in a single cutting operation. This concept is clarified further by Figures 6a to 6f which illustrate six steps in the operating cycle of a panel sawing machine equipped with at least one pickup element 16a, closest to the reference line RF, this time on the right, which can move backwards and forwards in direction K.

With reference to Figures 6a to 6f, the numeral 6 indicates the movable pusher, 7 the sawing device, 7-7 the cutting axis, and 3a and 3b two panels to be cut having different widths, equal total lengths (since they are derived from the same starting panel) but cut crossways along different lines to make different sized finished parts, labelled 40 and 41, respectively. In these drawings, the dashed lines on the panels indicate the lines along which they are to be sawn. The drawings show clearly that the boards 40 and 41 differ in length: the boards 41 on the right-hand panel are shorter than the boards 40 on the left-hand panel. The higher or lower number of parts 40 or 41 for each panel can be inverted with respect to the reference line RF. Figure 6a in

particular shows that the lines along which the two panels 3a and 3b will be cut do not coincide.

5 The first step in the panel cutting cycle (Figure 6a) is to drive the pusher 6 in such a way as to move the panels into position for the trimming cut. Trimming may not always be required.

10 For the second cut to be made in the panels (Figure 6b), the pusher 6 is moved forward and, at the same time, the right-hand panel 3b is moved backwards relative to it by the related pickup elements 16a so as to make the cutting lines of the two panels coincide.

For the third cut (Figure 6c), the right-hand panel is moved further back and for the fourth cut (Figure 6d) further back again.

15 The fifth cutting operation (Figure 6e) is applied only to the right-hand panel 3b and for it to be performed, the right-hand panel must be moved forward while keeping the pusher 6, and hence the left-hand panel 3a, in the same position.

20 The sixth and last cut (Figure 6f) is made in the same way as the first three.

25 It is evident, therefore, that by appropriately combining and programming the lengthways, crossways and vertical movements of the pusher and pickup elements, it is possible to simultaneously feed two or more panels, placed side by side, to a saw which cuts them into a large number of boards differing in size (both in length and width) using a relatively small number of cutting operations and hence saving a considerable amount of time.

30 The object of the present invention is achieved by the fact that the pusher crossbeam or crossbeams are not simply passive operating means but form part of an automated system whose essential parts, namely, the pickup elements, adjust automatically to the size and type of pickup of the panels or boards. Indeed, each pickup element can be regarded as a prehensile robotized device which can move in a line parallel to the axis of the crossbeam, in a line perpendicular to the axis of the crossbeam
35 and in a vertical line, all three of these controlled movements not being applied necessarily to all the pickup elements at the

same time but each one to one or more of the elements independently of the others, depending on the requirements connected with machine configuration.

Another distinctive feature of the invention is the use of a
5 rotation device that is extremely simple in construction and that works as follows:

- The pusher moves the panel (or stack) to a preset position.
- The grippers open.
- The pusher moves back a little way.
- 10 - The rotation element R grips the corner of the panel and, thanks to its jointed mounting, rotates the panel by moving lengthways in a straight line in direction F1 acting in combination with a reference element B1 that moves in a line at right angles to direction F1.

- 15 - During this operation, the pusher moves to a preset position defined in terms of the panel dimensions.

If the panel has to be rotated again after the pre-cuts have been made, this is done as follows:

- The pusher moves back in direction F1, while holding the
20 panel, in such a way as to move the remaining portion of the panel to a preset position.

- The grippers open.
- The pusher moves back a little way.
- The rotation element R grips the corner of the panel and,
25 with its jointed mounting acting as a pivot, waits for the reference element B1 to turn the panel by pushing it in a line at right angles to the forward and reverse feed directions F, F1.

- The rotation moves in direction F in synchrony with the reference element B1 to complete the 90° rotation.

30 The invention described can be subject to numerous modification in its constructional and application details but without thereby departing from the scope of the inventive concept as claimed below.

Claims

1. A panel sawing machine comprising: a horizontal table (5) to support at least one panel (30; 3a, 3b) to be cut; at least one movable device (6; 6a) designed to push the panel along the table in a feed direction (F; F2) or in a direction (F1; F3) opposite to this, in such a way as to feed a sawing device (7; 7a) and/or a rotation device (R), said sawing device (7; 7a) being designed to cut the panel (30; 3a, 3b) into two or more smaller boards (31; 4a, 4b) in a direction at right angles to the feed direction (F; F2), the movable device (6; 6a) being equipped with at least one pickup element (16) that holds the rear edge of the panel in position while it is being sawn, the machine being characterized in that the pickup element (16) is mounted on the movable device (6; 6a) in such a way that drive means (36) can move it in a horizontal direction (H) at right angles to the feed direction (F; F2).

2. The machine according to claim 1, characterized in that the pickup element (16) slides in a guide (15) that is integral with the movable device (6; 6a) and at right angles to the feed direction (F; F2).

3. The machine according to claim 1, characterized in that the movable device (6; 6a) is equipped with two or more of said pickup elements (16) mounted side by side in a horizontal direction (H) at right angles to the feed direction (F; F2), at least one of them being mounted on the movable device (6; 6a) in such a way that it can move in direction (H).

4. The machine according to claim 3, characterized in that at least one of the pickup elements, the one labelled (161), is mounted on the movable device (6; 6a) in such a way that drive means (38) can move it in the feed direction (F; F2) in both directions (K) relative to the movable device itself.

5. The machine according to claim 1, characterized in that the movable device (6; 6a) is equipped with two or more of said pickup elements (16, 161) mounted side by side in a horizontal direction (H) at right angles to the feed direction (F; F2), of which at least one (16) is mounted on the movable device (6; 6a) in such a way that it can move in direction (H) at right angles to the feed direction (F; F2), and at least one (161) is mounted on the movable device (6; 6a) in such a way that drive means (38) can move it in the feed direction (F; F2) in both directions (K) relative to the movable device itself.

6. The machine according to claim 1, characterized in that the movable device (6; 6a) is equipped with two or more of said pickup elements (16, 161, 162) mounted side by side in a horizontal direction (H) at right angles to the feed direction (F; F2), of which at least one (16) is mounted on the movable device (6; 6a) in such a way that it can move in direction (H) at right angles to the feed direction (F; F2), at least one (161) is mounted on the movable device (6; 6a) in such a way that drive means (38) can move it in the feed direction (F; F2) in both directions (K) relative to the movable device itself, and at least one (162) is mounted on the movable device (6; 6a) in such a way that drive means (39) can move it up and down in the vertical direction (Z).

7. The machine according to claim 1, characterized in that the movable device (6) forms part of a panel sawing machine with a single lengthways cutting axis (7) and is equipped with two or more of said pickup elements (16, 161) mounted side by side in a horizontal direction (H) at right angles to the feed direction (F), at least one of which is mounted on the movable device (6) in such a way that it can move in direction (H).

8. The machine according to claim 7, characterized in that at least one of the pickup elements, the one labelled (161), is mounted on the movable device (6) in such a way that drive means

(38) can move it in the feed direction (F) in both directions (K) relative to the movable device itself.

5 9. The machine according to claim 7, characterized in that the movable device (6) is equipped with two or more of said pickup elements (16, 161) mounted side by side in a horizontal direction (H) at right angles to the feed direction (F), of which at least one (16) is mounted on the movable device (6) in such a way that it can move in direction (H) at right angles to the feed direction (F), and at least one (161) is mounted on the movable device (6) in such a way that drive means (38) can move it in the feed direction (F) in both directions (K) relative to the movable device (6) itself.

15 10. The machine according to claim 7, characterized in that the movable device (6) is equipped with two or more of said pickup elements (16, 161, 162) mounted side by side in a horizontal direction (H) at right angles to the feed direction (F), of which at least one (16) is mounted on the movable device (6) in such a way that it can move in direction (H) at right angles to the feed direction (F); at least one (161) is mounted on the movable device (6) in such a way that drive means (38) can move it in the feed direction (F) in both directions (K) relative to the movable device itself; and at least one (162) is mounted on the movable device (6) in such a way that drive means (39) can move it up and down in the vertical direction (Z).

30 11. The machine according to claim 1, characterized in that the movable device (6, 6a) forms part of a panel sawing machine with two cutting axes, a lengthways cutting axis (7) and a crossways cutting axis (7a) related to a movable device (6) and (6a), respectively, each one of which is equipped with two or more of said pickup elements (16, 161) mounted side by side in a horizontal direction (H) at right angles to the feed directions (F) and (F2) respectively, at least one of the pickup elements of each movable device being mounted on the respective movable device (6; 6a) in such a way that it can move in direction (H).

12. The machine according to claim 11, characterized in that at least one of the pickup elements on each movable device (6; 6a), the one labelled (161), is mounted on the respective movable device in such a way that drive means (38) can move it in the feed direction (F; F2) in both directions (K) relative to the movable device itself.

13. The machine according to claim 11, characterized in that each movable device (6; 6a) is equipped with two or more pickup elements (16, 161) mounted side by side in a horizontal direction (H) at right angles to the feed direction (F; F2), of which at least one (16) is mounted on the movable device (6; 6a) in such a way that it can move in direction (H) at right angles to the feed direction (F; F2), and at least one (161) is mounted on the movable device (6; 6a) in such a way that drive means (38) can move it in the feed direction (F) in both directions (K) relative to the movable device (6) itself.

14. The machine according to claim 11, characterized in that each movable device (6; 6a) is equipped with two or more of said pickup elements (16, 161, 162) mounted side by side in a horizontal direction (H) at right angles to the feed direction (F; F2), of which at least one (16) is mounted on the movable device (6; 6a) in such a way that it can move in the horizontal direction (H) at right angles to the feed direction (F; F2); at least one (161) is mounted on the movable device (6; 6a) in such a way that drive means (38) can move it in the feed direction (F; F2) in both directions (K) relative to the movable device itself; and at least one (162) is mounted on the movable device (6; 6a) in such a way that drive means (39) can move it up and down in the vertical direction (Z).

15. A method for cutting panels in panel sawing machines that comprise: a horizontal table (5) to support at least one pair of panels (3a, 3b, ...3n) to be cut; a movable device (6; 6a) designed to push the panel along the table in a feed direction (F;

F2) to feed a sawing device (7; 7a) designed to cut the panels (3a, 3b, ... 3n) into two or more smaller boards (40, 41, ... 4N) in a direction at right angles to the feed direction (F; F2), the movable device (6; 6a) being equipped with at least two pickup
5 elements (16a, 16b, ... 16n) that hold the rear edge of each panel in position while it is being sawn, the method being characterized in that:

- the pickup elements (16a, 16b, ... 16n) used to implement it are mounted on the movable device (6; 6a) in such a way that all
10 of them, except one, if necessary, can be moved by drive means (36) in a horizontal direction (H) at right angles to the feed direction (F; F2);
- at least one of the pickup elements (16b...16n-1) is mounted in such a way that drive means (38) can move it in the feed direction
15 (F; F2) in both directions (K) relative to the movable device;
- each panel (3a, 3b, ... 3n) is picked up by a pickup element (16a, 16b, ... 16n) and that the pickup element (16b...16n-1) is moved in the feed direction (F; F2) in both directions (K) relative to the movable device in such a way as to position the
20 panels (3a, 3b, ... 3n) so that the lines along which they have to be cut are aligned before they are fed to the sawing device (7; 7a).

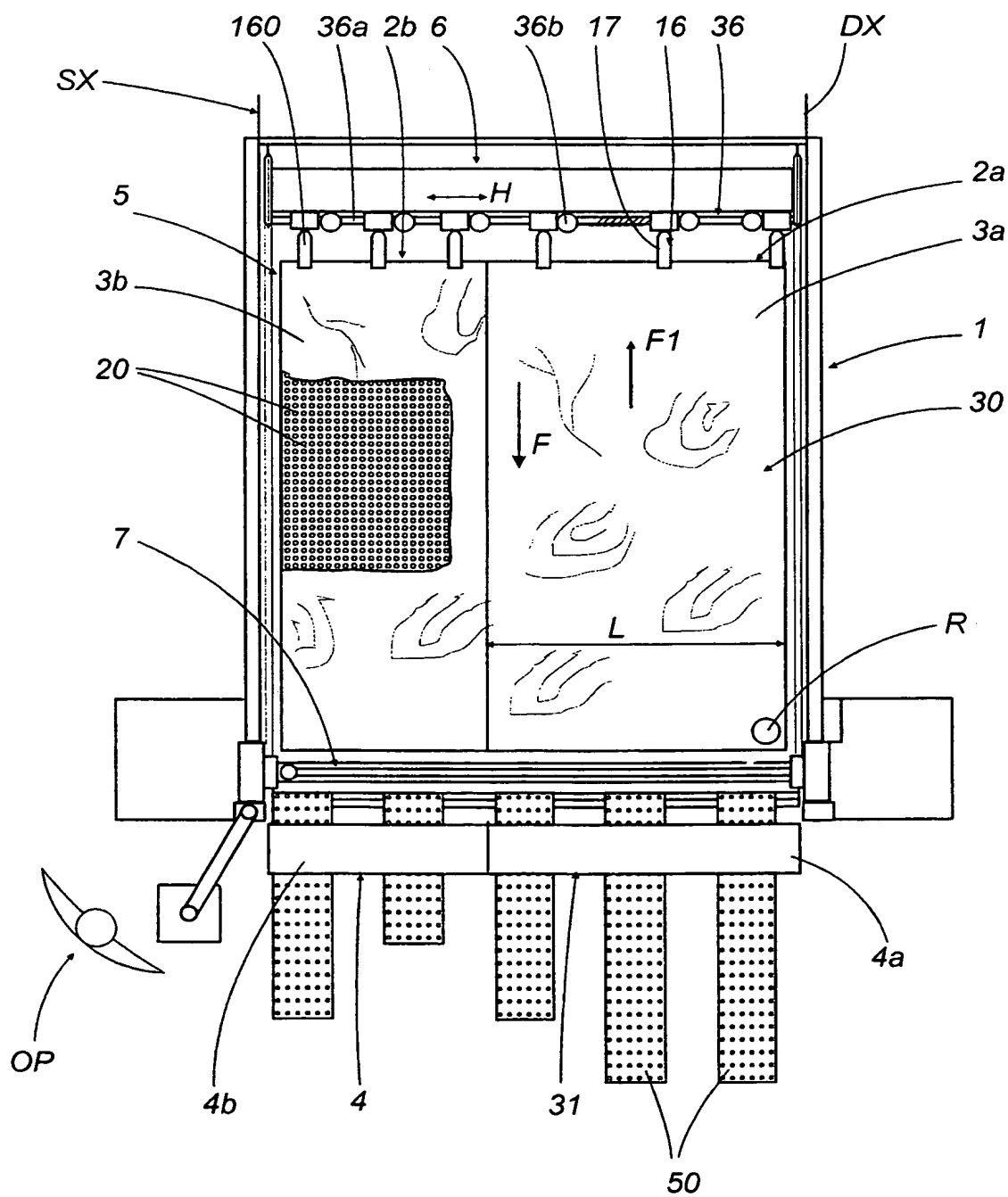
16. The method according to the previous claim, characterized in
25 that:

- the pickup elements (16a, 16b, ... 16n) used to implement it are mounted on the movable device (6; 6a) in such a way that all of them, except one, if necessary, can be moved by drive means (36) in a horizontal direction (H) at right angles to the feed
30 direction (F; F2);
- at least one of the pickup elements (16b...16n-1) is mounted in such a way that drive means (38) can move it in the feed direction (F; F2) in both directions (K) relative to the movable device;
- at least one of the pickup elements (16b...16n-1) is mounted in
35 such a way that drive means (39) can move it in a vertical direction (Z);

said movements making it possible for the movable device (6; 6a) to return in a direction opposite the forward feed direction (F; F2) and pass over a panel positioned on the table (5); with some of the pickup elements, the ones labelled (162), having risen to a given height along the axis (Z) so as not to interfere with said panel, and some of the pickup elements, the ones labelled (161), having moved crossways in the horizontal direction (H) to a lateral position outside the area occupied by the panel.

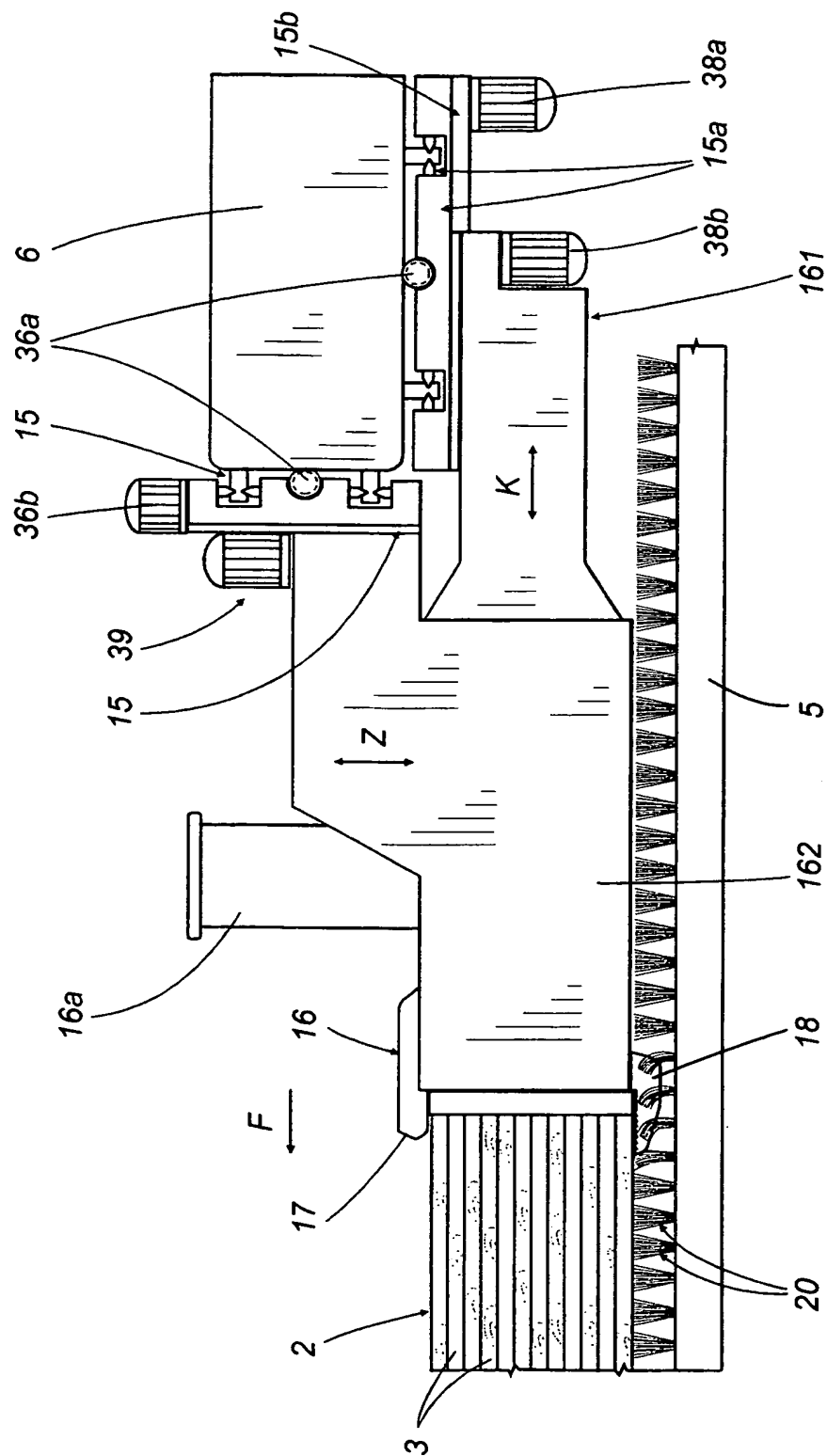
1/15

FIG.1



2/15

FIG. 2



3/15

FIG.3a

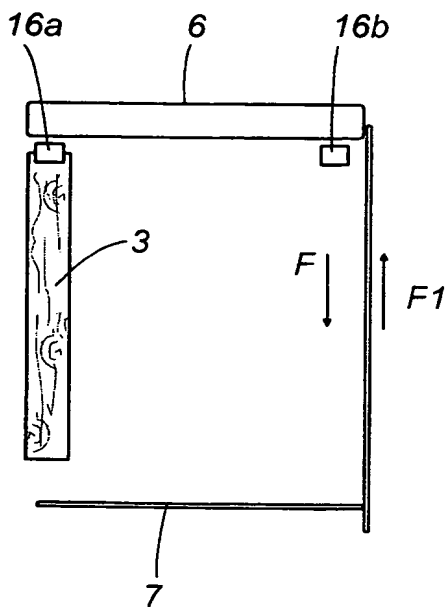


FIG.3b

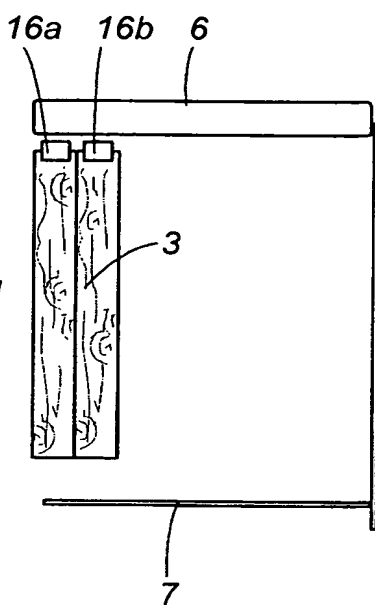


FIG.3c

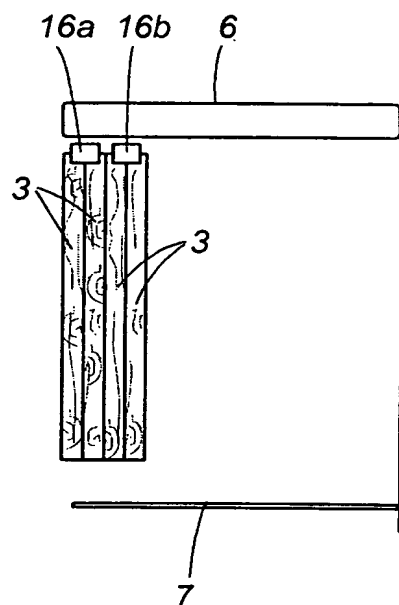


FIG.3d

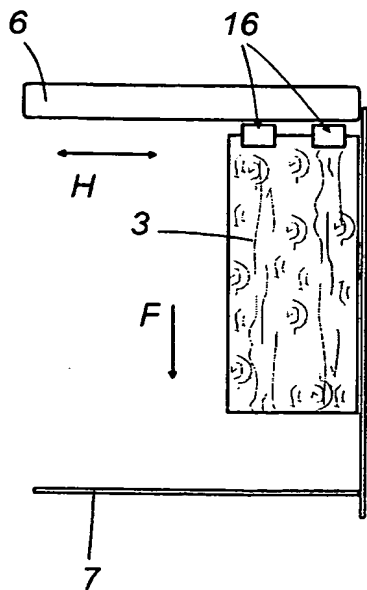


FIG.3e

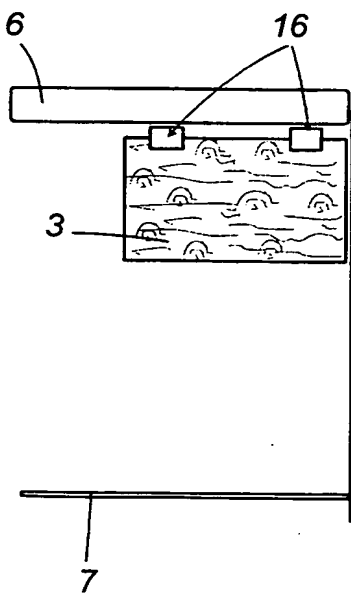
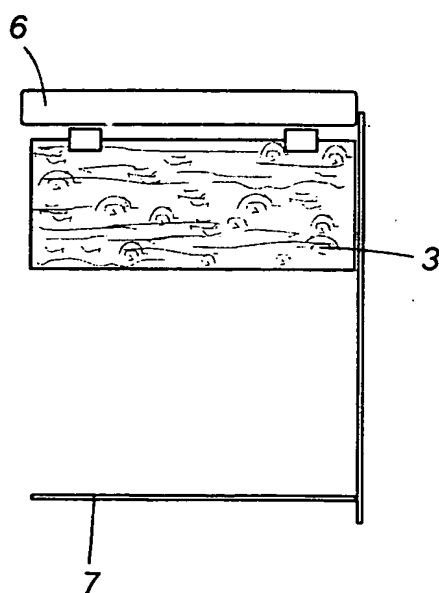


FIG.3f



4/15

FIG. 4a

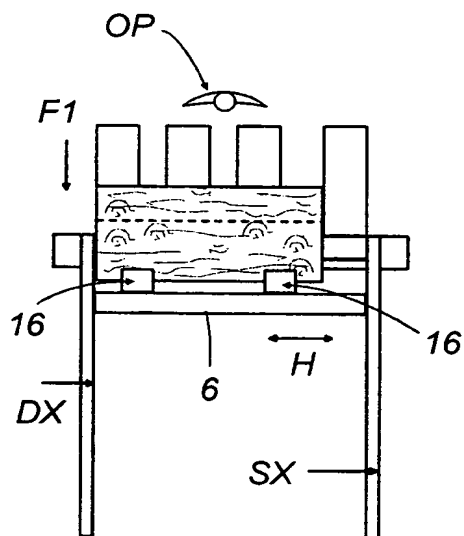


FIG. 4b

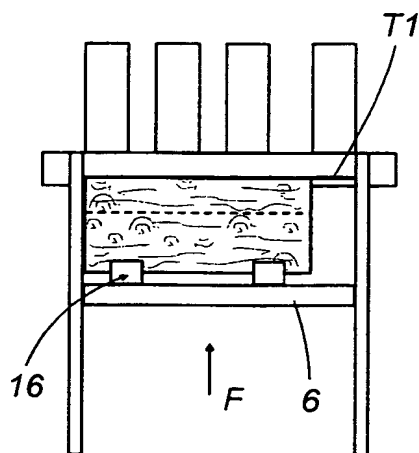


FIG. 4c

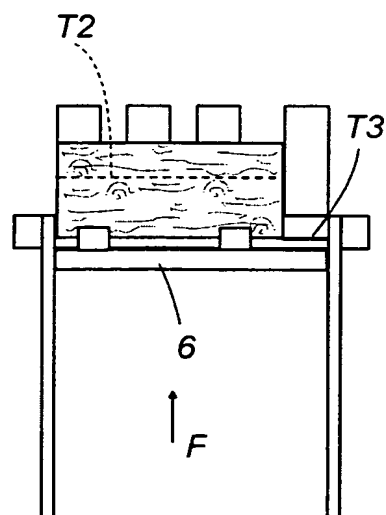


FIG. 4d

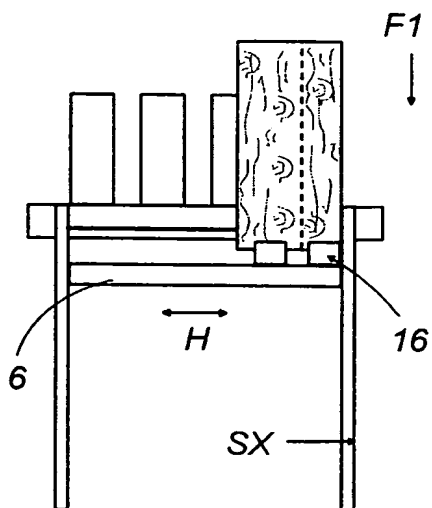


FIG. 4e

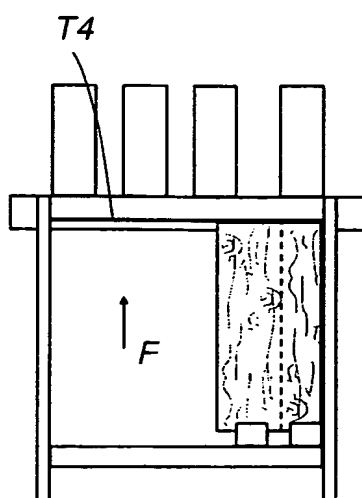
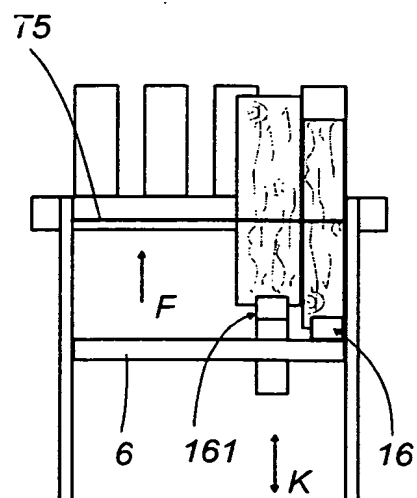


FIG. 4f



5/15

FIG. 4g

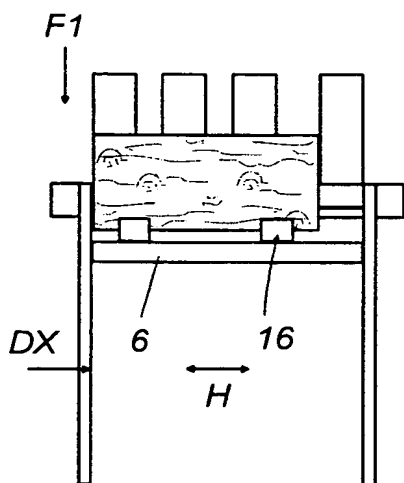


FIG. 4h

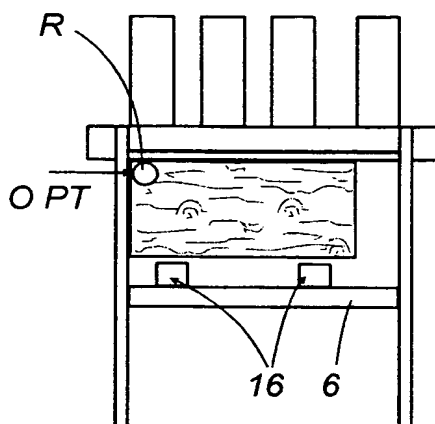


FIG. 4i

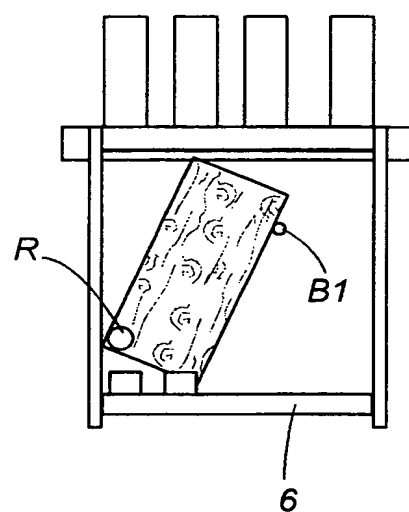


FIG. 4j

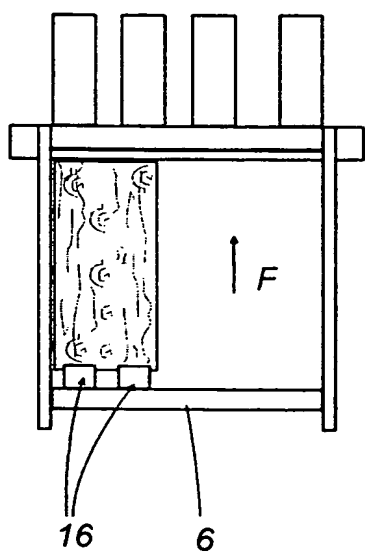


FIG. 4k

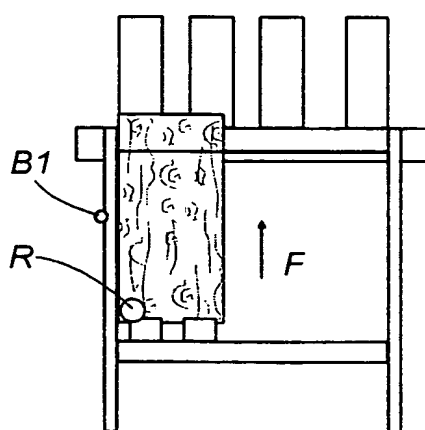
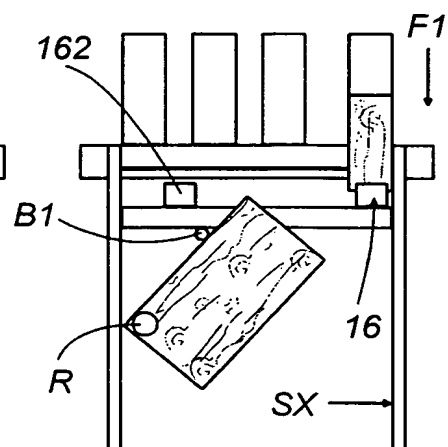


FIG. 4l



6/15

FIG.4m

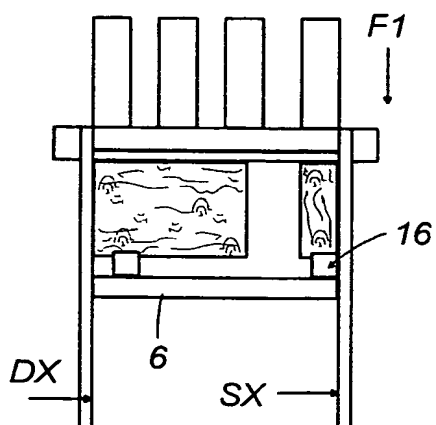


FIG.4n

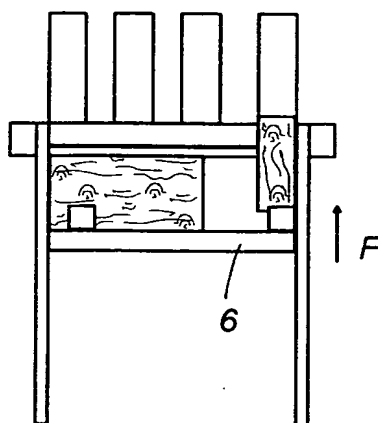


FIG.4o

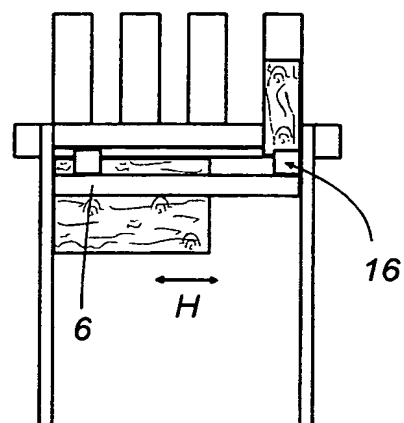


FIG.4p

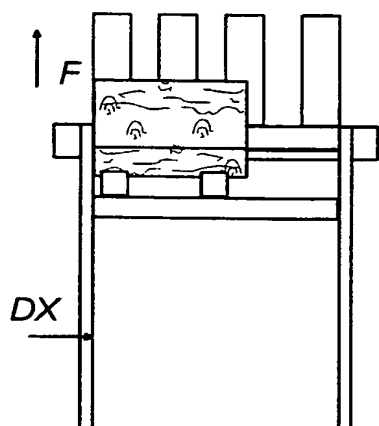


FIG.4q

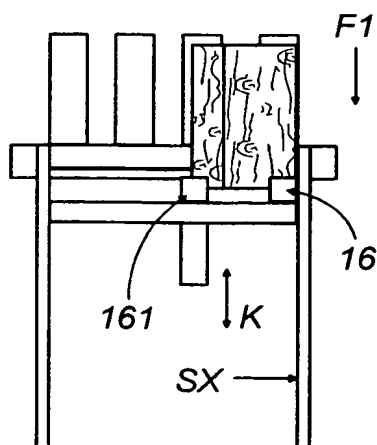
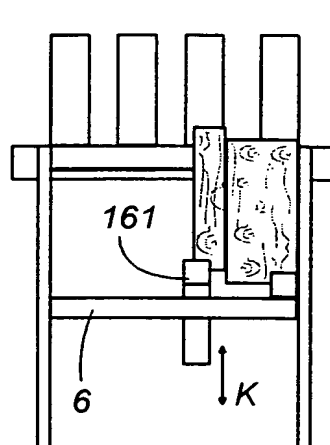


FIG.4r



7/15

FIG. 4u

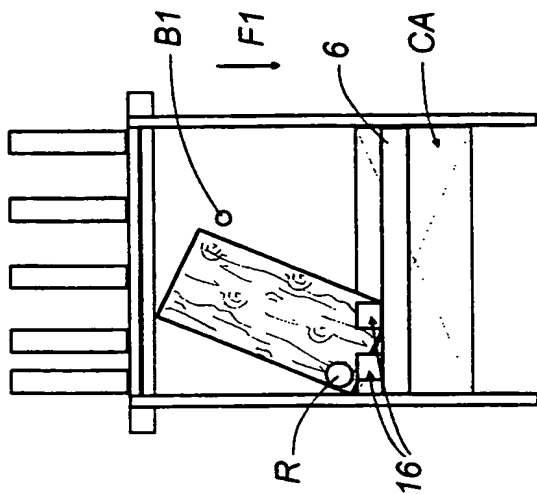


FIG. 4x

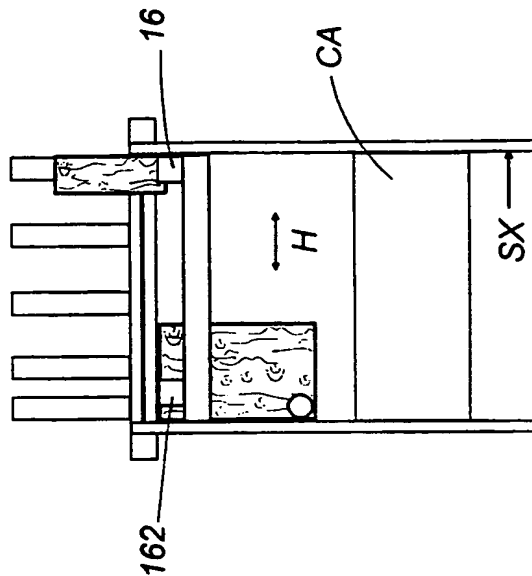


FIG. 4t

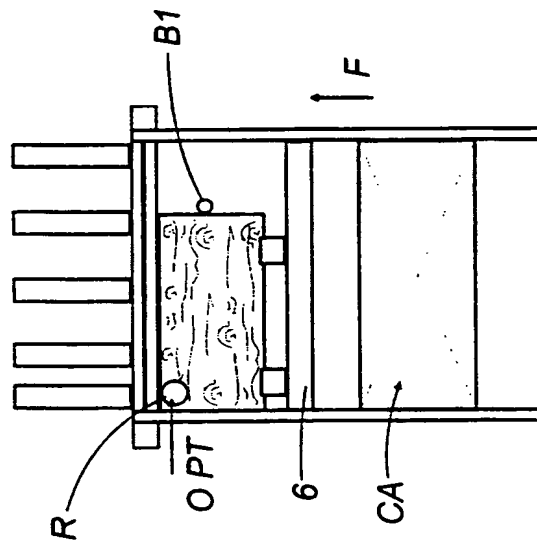


FIG. 4w

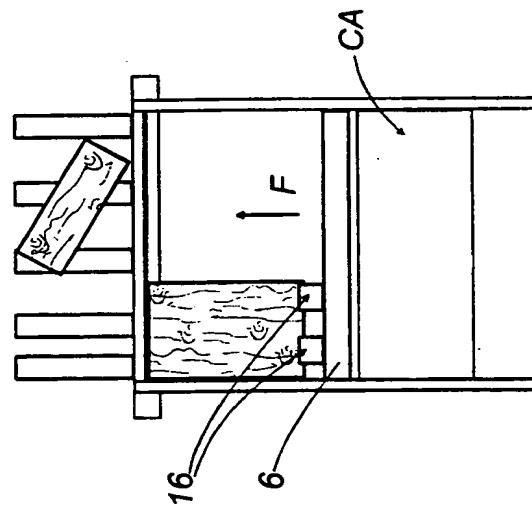


FIG. 4s

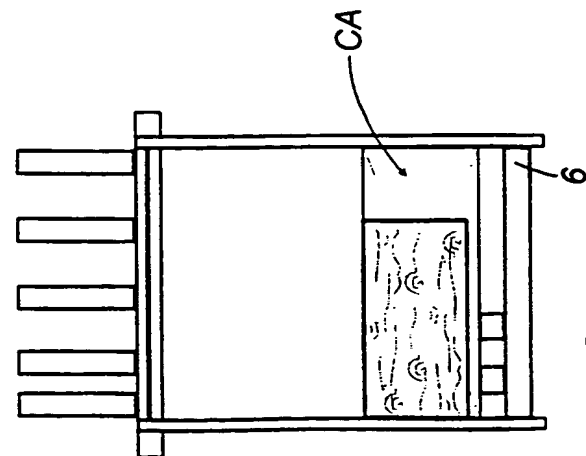
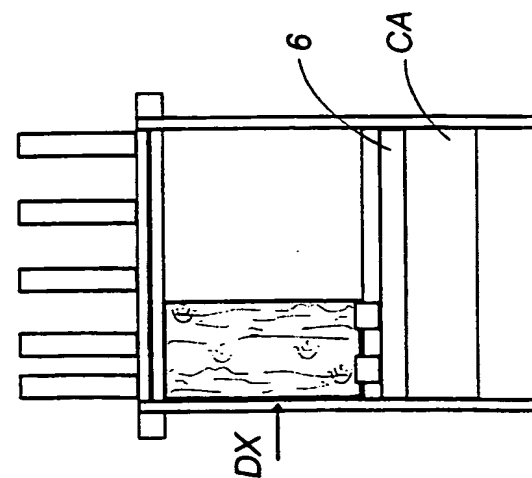


FIG. 4v



8/15

FIG. 4a1

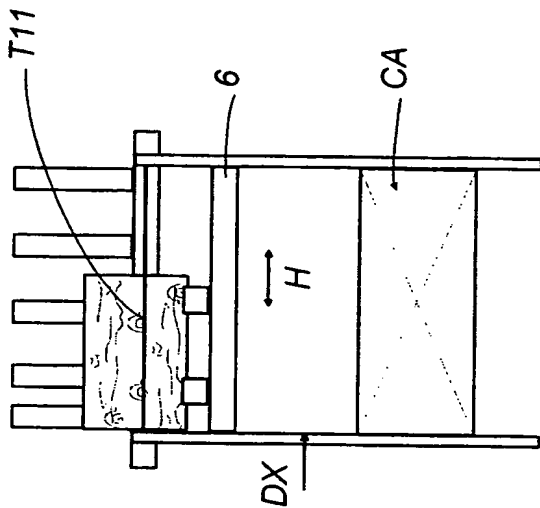


FIG. 4z

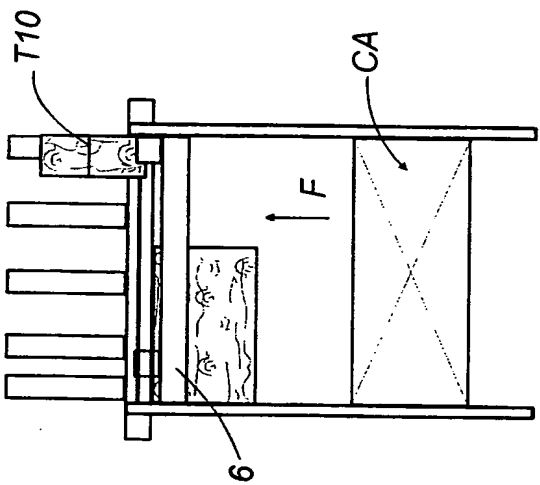


FIG. 4y

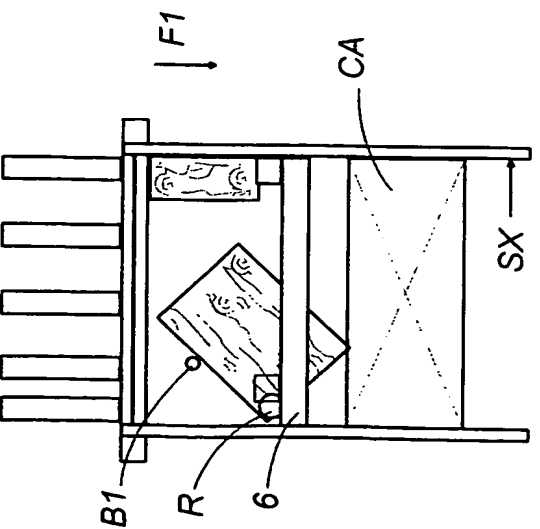


FIG. 4d1

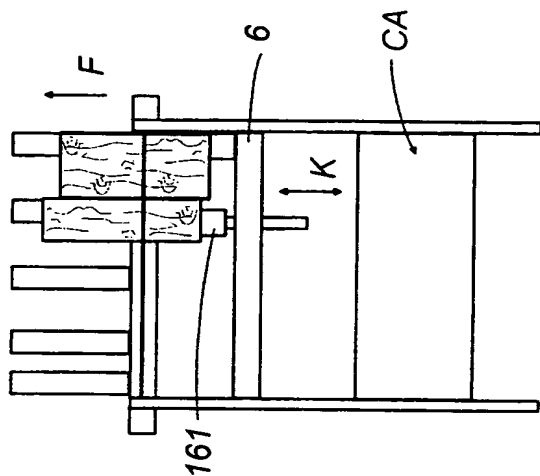


FIG. 4c1

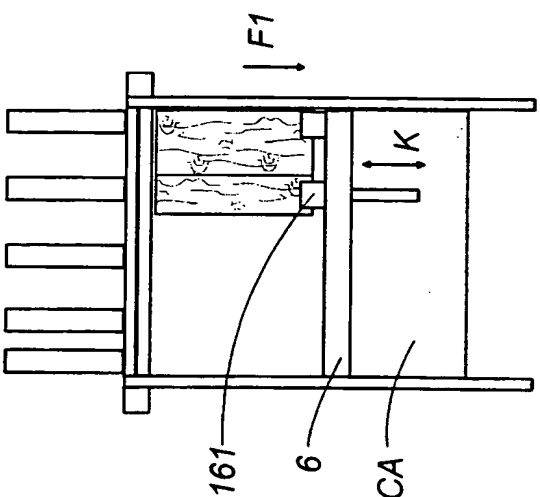
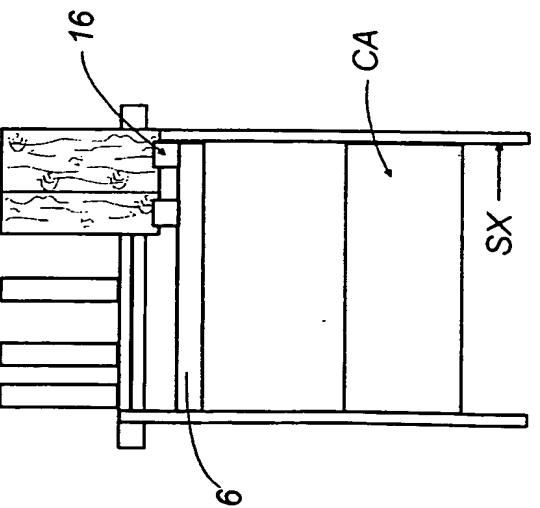
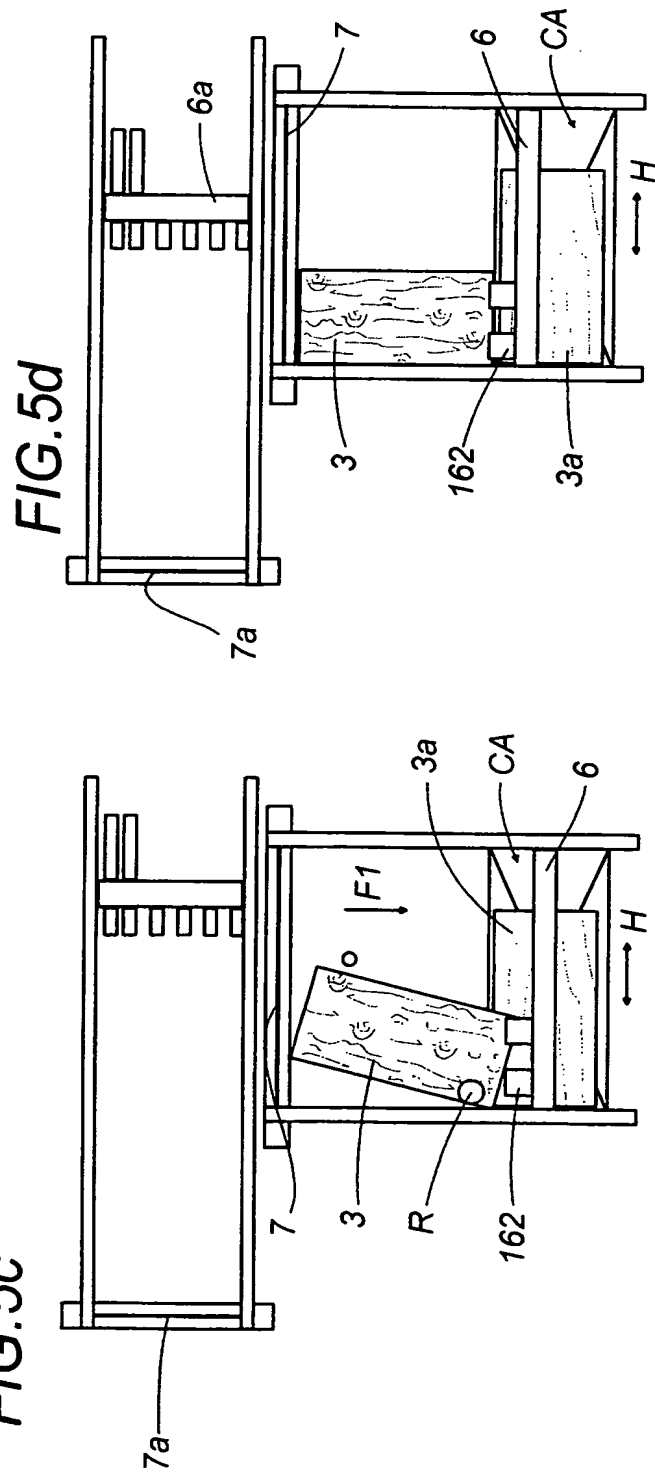
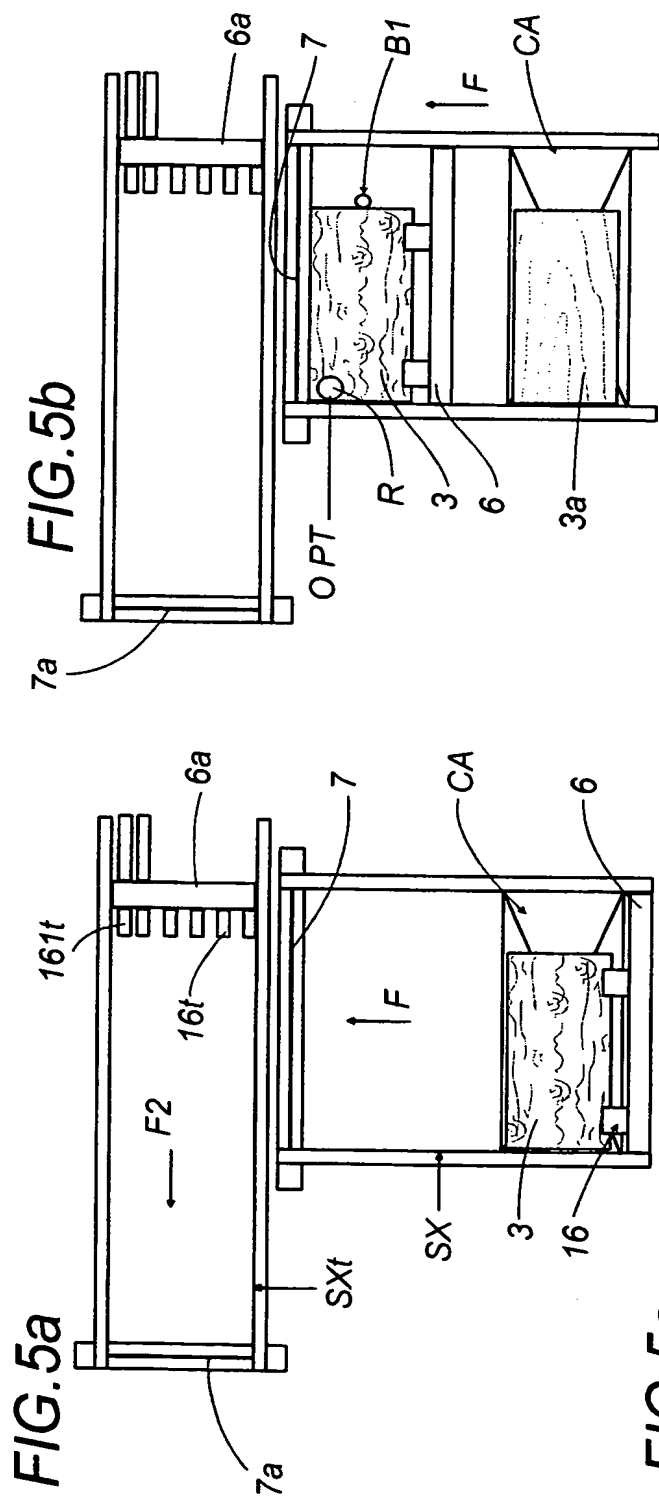


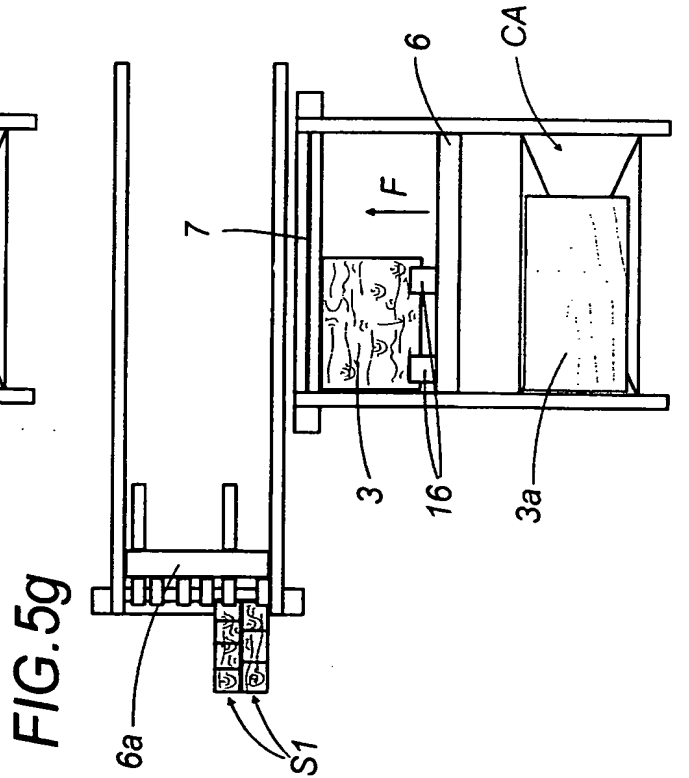
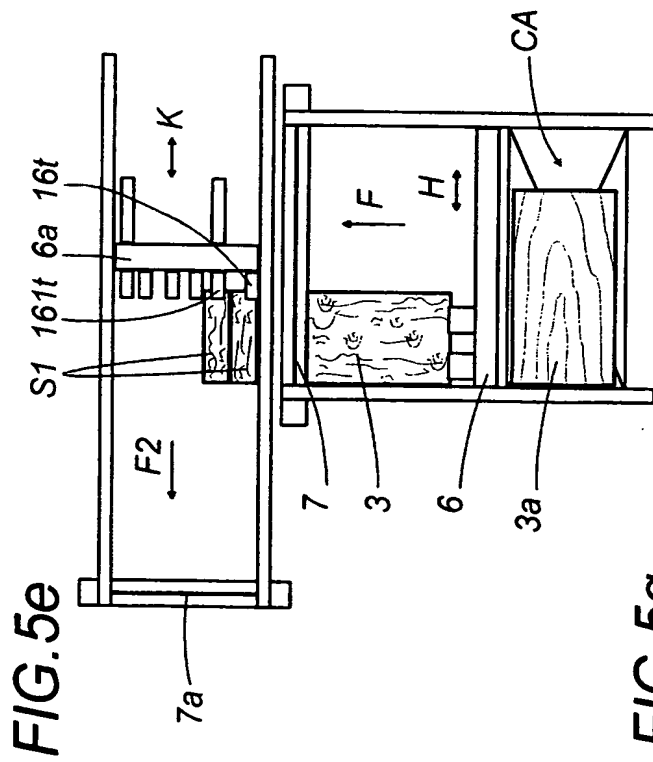
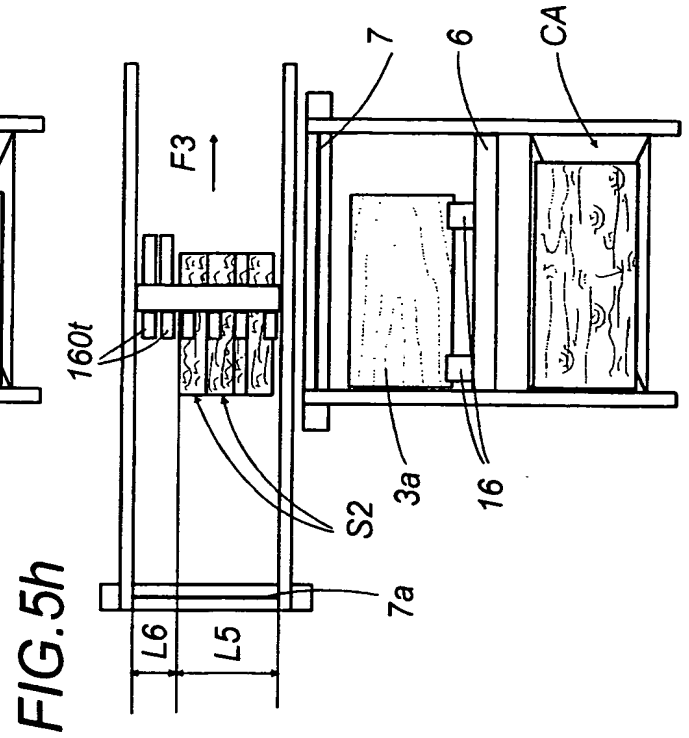
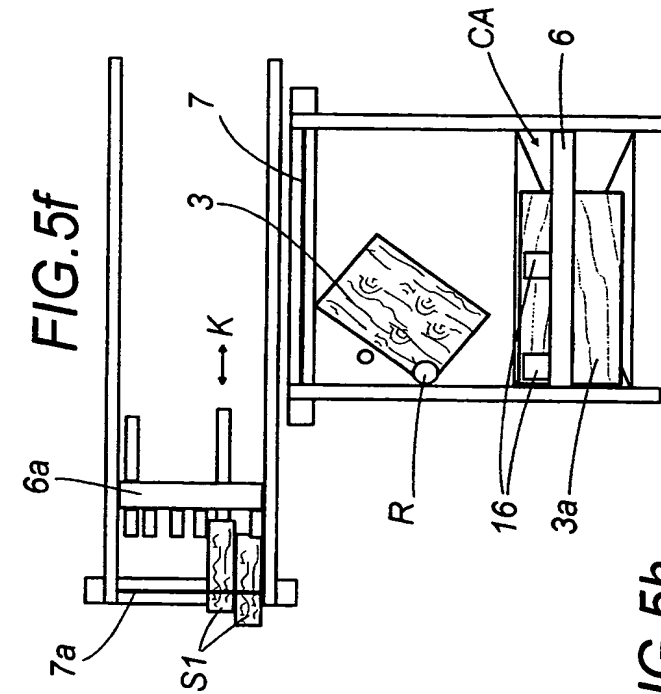
FIG. 4b1



9/15



10/15



11/15

FIG.5j

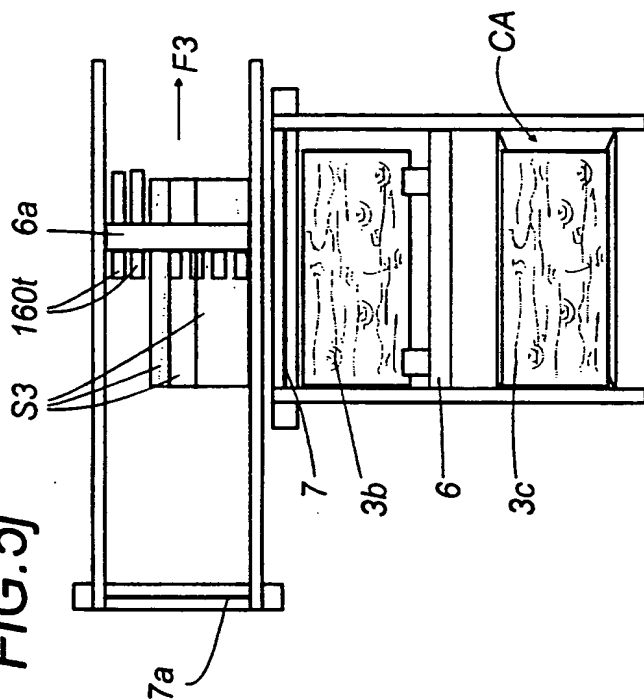


FIG.5i

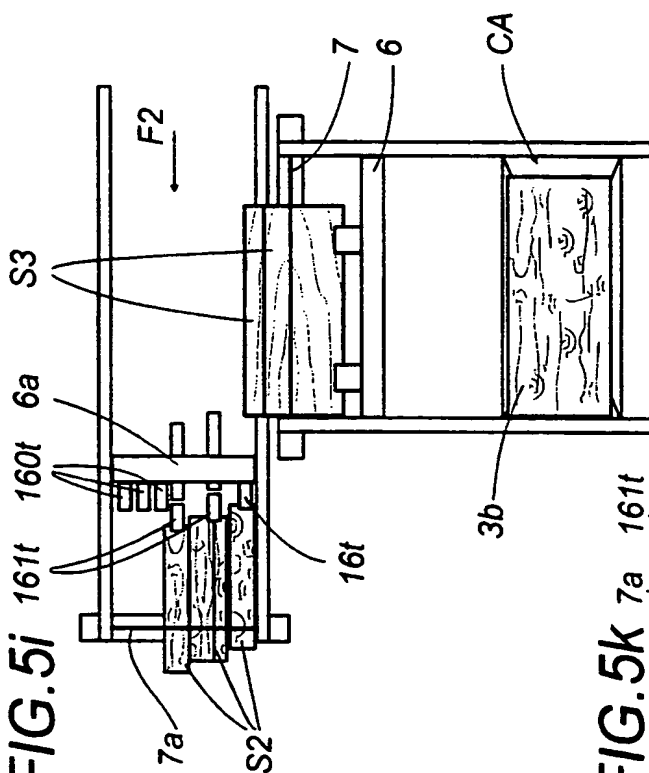
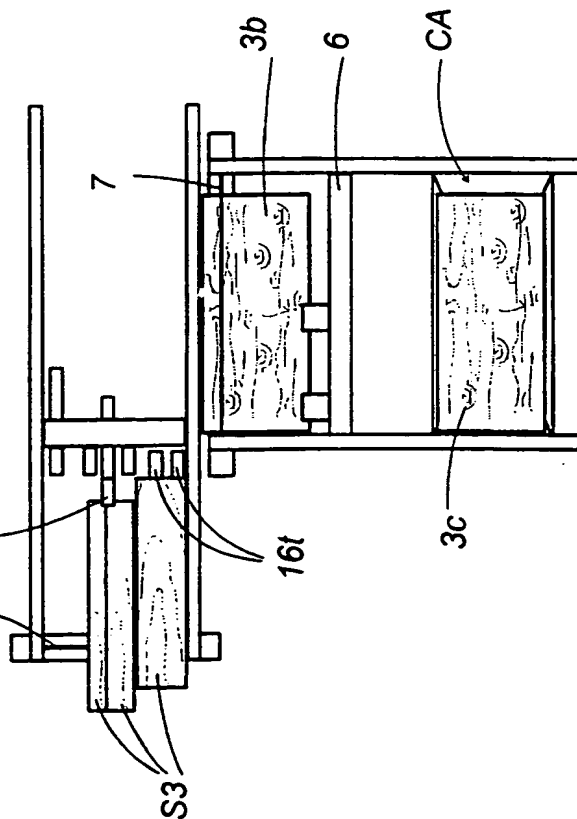
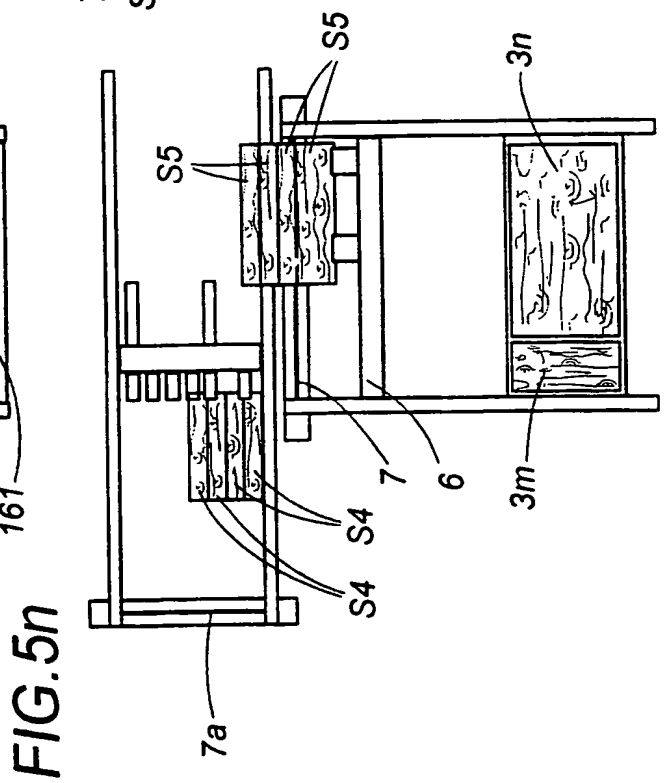
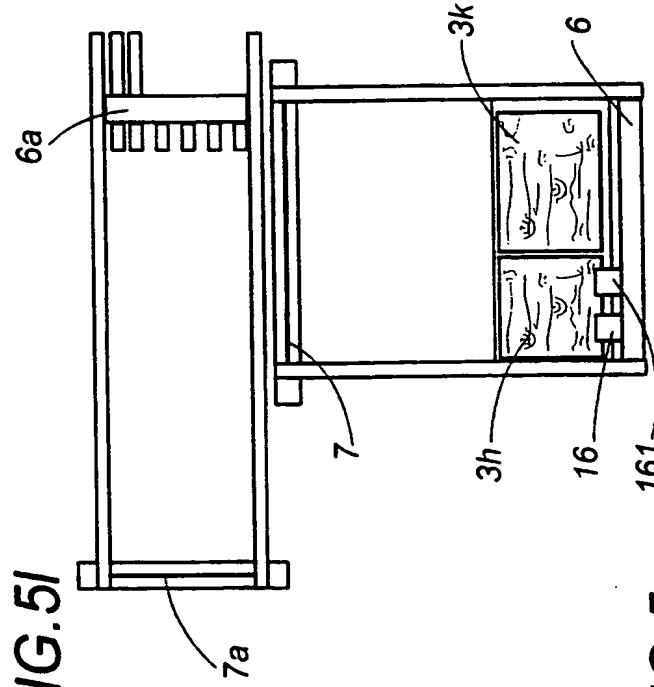
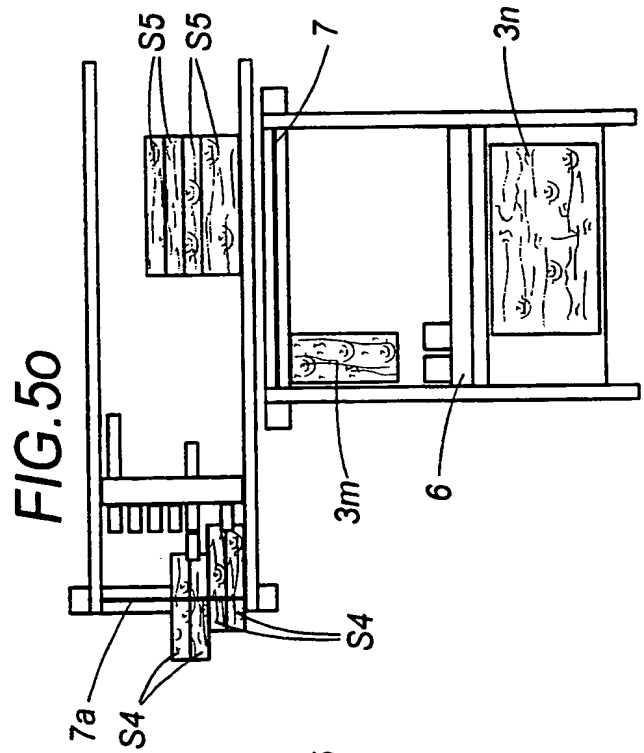
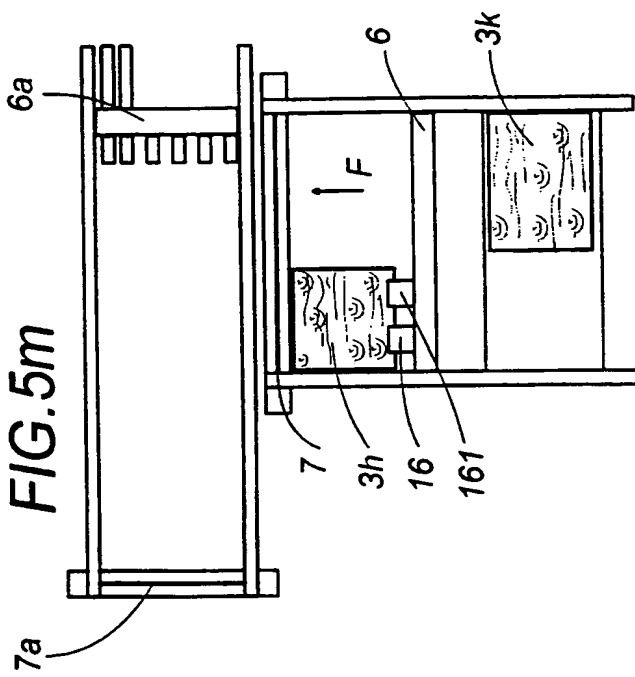


FIG.5k



12/15



13/15

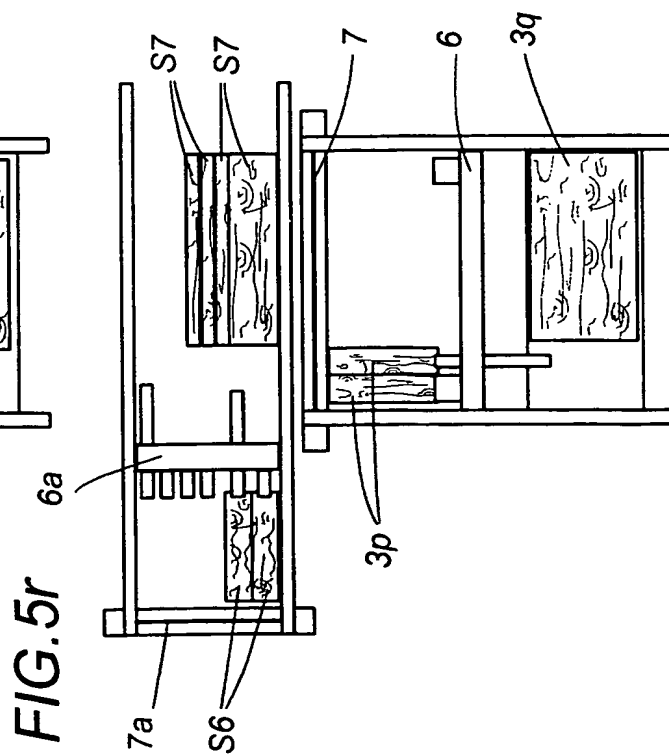
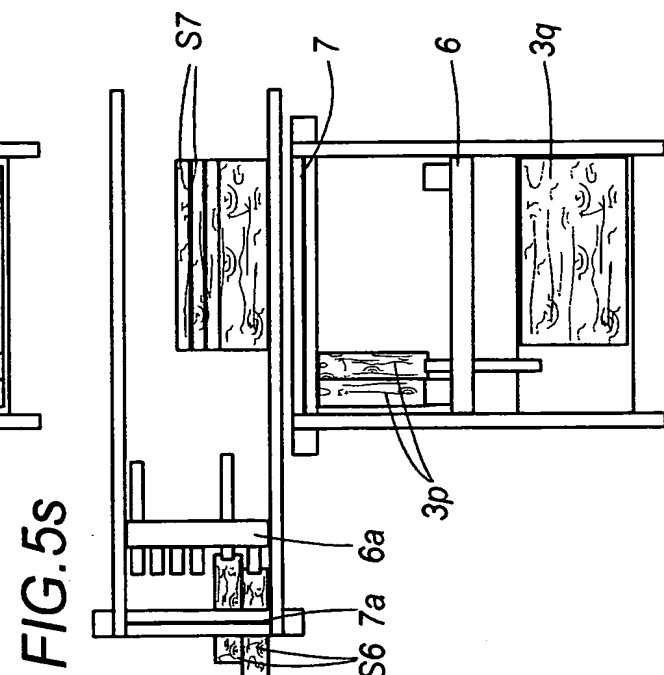
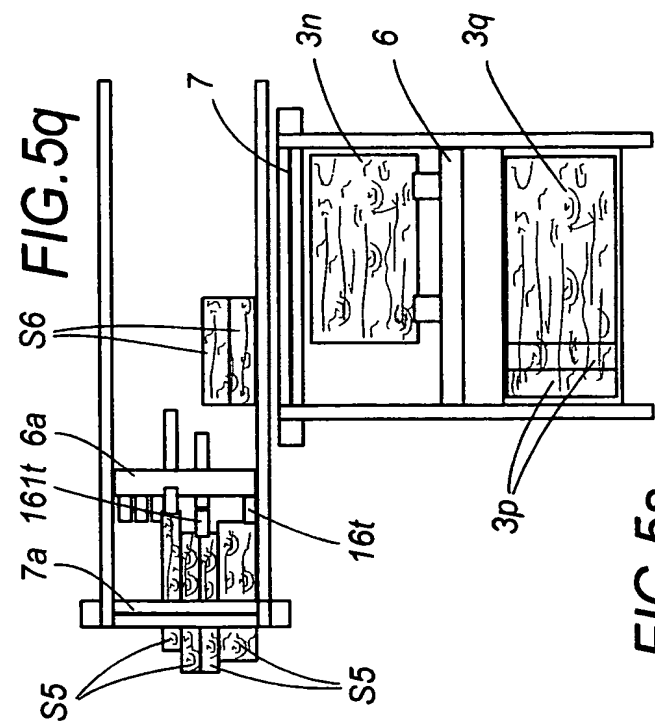
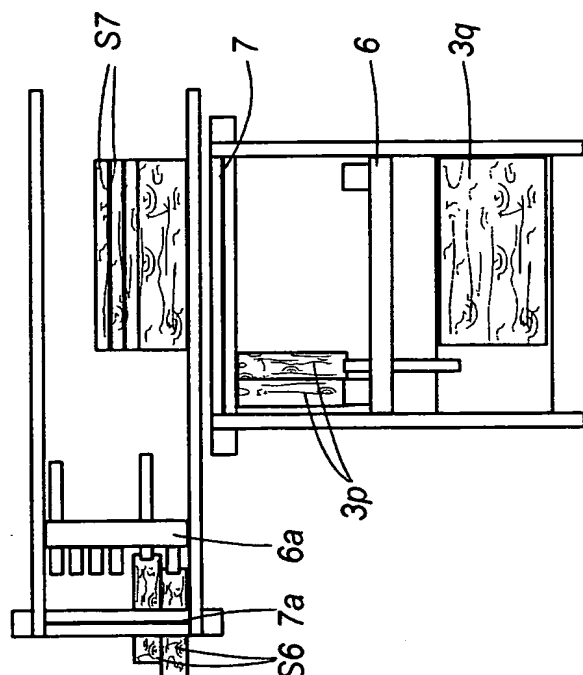


FIG. 5s



14/15

FIG.5u

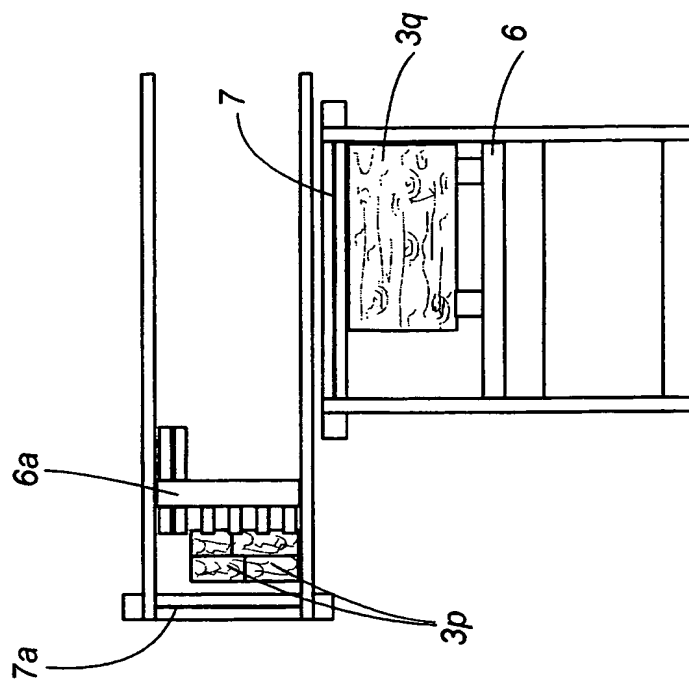
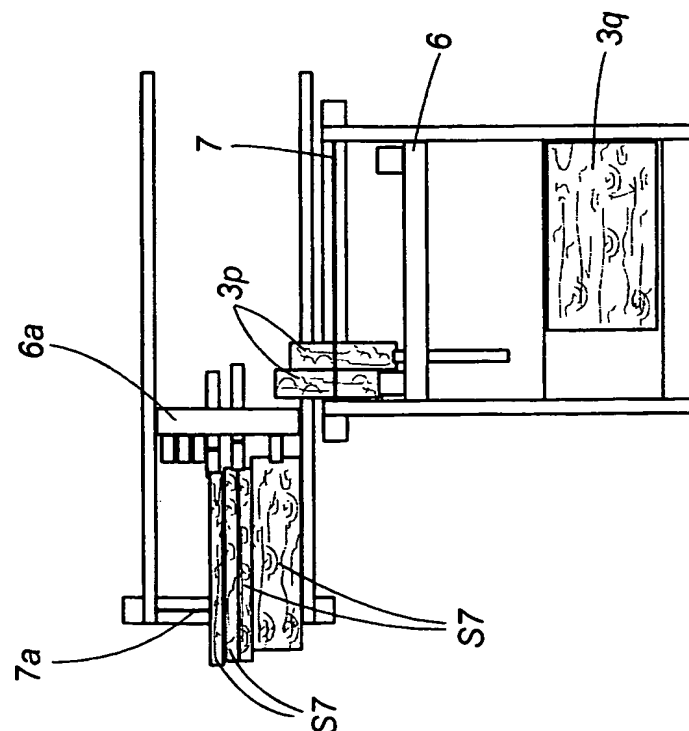
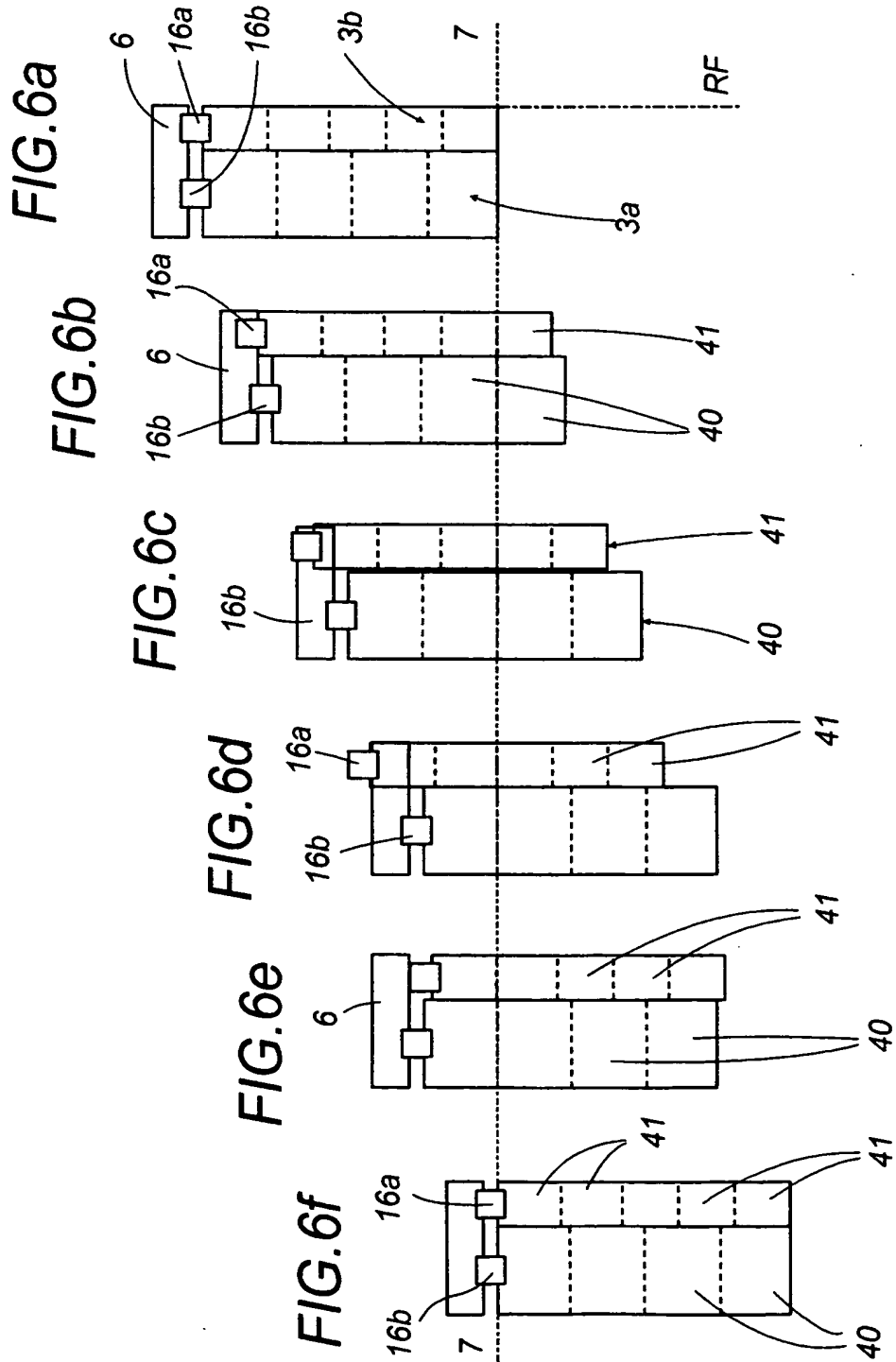


FIG.5t



15/15



INTERNATIONAL SEARCH REPORT

Intern al Application No
PCT/IB 98/02046

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 B23D47/04 B27B5/06

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 B23D B27B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 37 32 556 A (SCHELLING & CO) 28 April 1988 see column 4, line 29 - line 38 see column 5, line 35 - line 48; figures	1-3
Y	---	4-16
Y	EP 0 184 642 A (E. JENKNER) 18 June 1986 see page 7, line 30 - page 8, line 9 see page 8, line 22 - line 30 see figures 1,2	4-16
A	---	
A	DE 44 16 486 A (SCHELLING & CO) 15 December 1994 see column 3, line 14 - line 19; figure 5	1
A	---	
A	EP 0 200 120 A (E. JENKNER) 5 November 1986	

	-/--	

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☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

11 March 1999

Date of mailing of the international search report

19/03/1999

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C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

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A	DE 26 34 487 A (WEHNER KG) 2 February 1978 -----	

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/IB 98/02046

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PATENT COOPERATION TREATY

PCT

INTERNATIONAL SEARCH REPORT

(PCT Article 18 and Rules 43 and 44)

Applicant's or agent's file reference 61. G3440.W07	FOR FURTHER ACTION see Notification of Transmittal of International Search Report (Form PCT/ISA/220) as well as, where applicable, item 5 below.	
International application No. PCT/IB 98/02046	International filing date (day/month/year) 17/12/1998	(Earliest) Priority Date (day/month/year) 24/12/1997
Applicant GIBEN IMPIANTI S.P.A. et al.		

This International Search Report has been prepared by this International Searching Authority and is transmitted to the applicant according to Article 18. A copy is being transmitted to the International Bureau.

This International Search Report consists of a total of 3 sheets.

☒ It is also accompanied by a copy of each prior art document cited in this report.

1. Basis of the report

- a. With regard to the **language**, the international search was carried out on the basis of the international application in the language in which it was filed, unless otherwise indicated under this item.

☐ the international search was carried out on the basis of a translation of the international application furnished to this Authority (Rule 23.1(b)).

- b. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application, the international search was carried out on the basis of the sequence listing :

☐ contained in the international application in written form.

☐ filed together with the international application in computer readable form.

☐ furnished subsequently to this Authority in written form.

☐ furnished subsequently to this Authority in computer readable form.

☐ the statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.

☐ the statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished

2. ☐ **Certain claims were found unsearchable** (See Box I).

3. ☐ **Unity of invention is lacking** (see Box II).

4. With regard to the title,

☐ the text is approved as submitted by the applicant.

☒ the text has been established by this Authority to read as follows:

METHOD AND MACHINE FOR SAWING PANELS WITH Laterally MOVABLE Pusher

5. With regard to the abstract,

☒ the text is approved as submitted by the applicant.

☐ the text has been established, according to Rule 38.2(b), by this Authority as it appears in Box III. The applicant may, within one month from the date of mailing of this international search report, submit comments to this Authority.

6. The figure of the drawings to be published with the abstract is Figure No.

☒ as suggested by the applicant.

☐ because the applicant failed to suggest a figure.

☐ because this figure better characterizes the invention.

2

☐ None of the figures.